

Hampshire Mill
A Division of Combined Metals of Chicago LLC

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ESM IS YOUR CHOICE FOR LIGHT GAUGE STAINLESS STEEL PRECISION STRIP AND HIGH PERFORMANCE ALLOYS





Hampshire Mill

WHAT IS ESM?

Our state-of-the-art conversion mill is built on a 25-acre site in Hampshire, Illinois. Our customers are the main focus of our continued long-term success. ESM is the leading manufacturer of light gauge stainless strip which is produced to precision thickness and widths based upon customer specifications.

WHY ESM?

ESM offers short lead times and smaller minimum quantities than our competitors which allow customers the ability to receive material in the same month an order is taken. We value our customers; therefore, we have and always will be a customer-driven company. Our facility and "can-do" service center philosophy set new industry standards.

ESM CAPABILITIES _

Sundwig 40" Reversing Mill



This versatile 20 High Mill is capable of rolling all types of stainless steel alloys from .100" in thickness to as thin as .004". The mill is equipped with Automatic Gauge Control and Automatic Shape Control systems. Thickness can be controlled to within +/- 1% of the target thickness longitudinally. Strip shape measurements and automated control of the actuators provides uniform flatness across the strips profile. For cost control and efficiency, the rolling mill operates at speeds near 2,000 FPM.

40" Ebner and 52" Drever Bright Anneal Furnaces

Stainless and specialty alloys are annealed on one of the two bright annealing lines. The automation and temperature control of these units allow ESM to offer very specific mechanical property requirements. These lines can also be used exclusively for cleaning of temper rolled material.

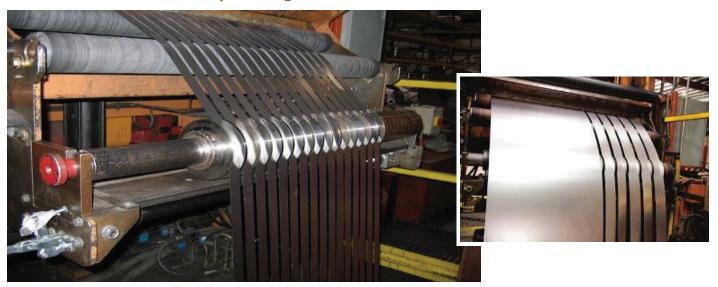


52" Herr-Voss Tension Leveler



Coils are leveled on this unique machine through a combination of tension and roller leveling. The automatic drive system controls strip elongation to within +/- .02%. One of the two flattener designs engage the metal as it is pulled through the leveling device providing strip flatness for the most critical applications. Strip steepness ratings of less than 2% are routinely achieved and certified.

40" and 52" Precision Strip Slitting



ESM is capable of slitting material as thin as .002" as well as widths from 52" to cuts as narrow as .188".

ESM manufactures all 200, 300, and 400 series stainless steel alloys in both the annealed and tempered condition. We also have the capability of producing nickel, titanium, and 17-7PH alloys upon request.

All material is certified to customer and industry specifications. With our own metallurgists and our onsite laboratory, metallographic and analysis is performed routinely. To complement its automation, ESM has a highly-skilled and motivated workforce. ESM's experienced operating and quality staff can be consulted and are able to provide feedback on many different issues. Our direct contact with the customer ensures problems will be understood, communicated, and corrected.

Coil Degreasing / Clean Line



Stainless and other specialty alloy coils up to 56" wide and up to 0.060" thick are fed via driven rolls through a heated fluid wash zone. Within this zone, high pressure sprays utilizing more than 120 gal/min of fluid are used to degrease the strip. The strip is then run through a heated drying section at speeds up to 200ft/min to produce a clean, dry, high-quality steel product for our customers.



ESM LAB _

ESM's 4,200 square foot R&D and laboratory located at our ISO 9001:2015 / AS9100 D accredited Hampshire facility is accredited to both ISO 17025 (through A2LA) and Nadcap Materials Test Lab (through PRI). With our four tensile testing frames, we can pull material with a yield strength of 1/4 pound all the way up to 120,000 pounds of force. Other common tests performed include: bend, wrap testing, hardness/microaggression, corrosion, and many microscopy tests including grain size, IGA/IGO, alloy depletion, alpha case, inclusion rating, etc. Our laboratory is open seven days a week to ensure fast and accurate testing!



Certifications:

AS9100:2016 & ISO9001:2015
ISO/IEC 17025:2017
PED Certificate of Conformance
Minority Business Enterprise Certificate
RoHS Directive
Reach Certification
Conflict Minerals

Approvals: Pratt & Whitney



	Grade	Anneale	ed		1/4 Hard	1/2 Hard	3/4 Hard	Full Hard
	201 A	ASTM-A-240	ASTM-A-666					
STAINLESS		ASTM-A-240 ASTM-A-240	ASTM-A-666		AMS-5517	AMS-5518	AMS-5902	AMS-5519
	302 A	ASTM-A-240	ASTM-A-666		ASTM-A-666 AMS-5903	ASTM-A-666 AMS-5904	ASTM-A-666 AMS-5905	ASTM-A-666 AMS-5906
STEEL	302 P	NOTIVI-A-240	ASTIVI-A-000			ASTM-A-666	ASTM-A-666	
REFERENCE	304 A	ASTM-A-240	ASTM-A-666	ASME-SA-240	Λ ς ΤΜ_Λ_501(0 ASTM-A-5911	AMS_5012	AMS-5513
GUIDE		NOTIVI-A-240	ASTIVI-A-000	ASIVIE-SA-240		ASTM-A-666	AIVIO-3912	AIVIS-3313
GOIDE		ASTM-A-240 ASTM-A-240	ASTM-A-666	ASME-SA-240 ASME-SA-240	ASTM-A-666	ASTM-A-666		
		ASTM-A-240	ASTM-A-666	ASME-SA-240				
	321 A	ASTM-A-240		ASME-SA-240		ASTM-A-666		
		ASTM-A-240		ACIVIL CALL TO				
	Other alloy	s available upon	request.					
	Finish D	escription		Process		Designatio	n	
	Comme	rcial 1BA		Ground Ro		BA1		
SURFACE	Smooth/Brite 2BA		Ground & Polish		BA2			
FINISHES	1BA Polish Quality		Ground & Controlled		BA3			
OFFERED	Ultra Smooth 2BA 2B Alternative			Proprietary	Ground & Polish BA4 Proprietary CA1			
OFFERED		2D Dull Surface			Proprietary C			
	Dull High	h Friction		Proprietary		CA3		
	Lite Mat	te		Proprietary		CA4		
	Other finish	nes available upo	n request.					
	Thickne	ess Toleran	ces (inches)		Width Tolera	nces (inches)		
	Thickne		ces (inches)	I	Width Tolera	nces (inches)		
STAINLESS	Thickne			12" to 24"		nces (inches)	Thickness (inch	es) under .069
	In Inches	Width 1/8" to 6" incl. +/- 9 .002	6" to 12" incl. +/-	incl. +/- .003	No. 3 Slit Edges Width (Inches) .187 to .500	nces (inches)	Thickness (inch (+ /005)	ies) under .069
STAINLESS STEEL STRIP	.040049 .035039 .029034	Width 1/8" to 6" incl. +/- 9 .002 9 .002 9 .0015	6" to 12" incl. +/- .003 .002 .002	incl. +/- .003 .002 .002	No. 3 Slit Edges Width (Inches) .187 to .500 .500 to 6 Over 6 to 9	nces (inches)	Thickness (inch (+ /005) (+ /005) (+ /005)	es) under .069
	In Inches .040049 .035039	Width 1/8" to 6" incl. +/- 9 .002 9 .002 9 .0015 9 .0015	6" to 12" incl. +/003 .002	incl. +/- .003 .002	No. 3 Slit Edges Width (Inches) .187 to .500 .500 to 6	nces (inches)	Thickness (inch (+ /005) (+ /005)	ies) under .069
	In Inches .040049: .035039: .029034: .020028:	Width 1/8" to 6" incl. +/- 9 .002 9 .002 9 .0015 9 .0015 9 .001 9 .001	6" to 12" incl. +/- .003 .002 .002 .0015	incl. +/003 .002 .002 .0015	No. 3 Slit Edges Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99		Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001)	ies) under .069
	.040049! .035039! .029034! .020028! .017019! .013016! .011012!	Width 1/8" to 6" incl. +/- 9 .002 9 .0015 9 .0015 9 .001 9 .001 9 .001	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .0011	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0015	No. 3 Slit Edges Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol	lerances	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002)	
	.040049: .035039: .029034: .020028: .017016: .013016:	Width 1/8" to 6" incl. +/- 9 .002 9 .0015 9 .0015 9 .001 9 .001 9 .001 9 .001	6" to 12" incl. +/- .003 .002 .002 .0015 .0015 .0015	incl. +/003 .002 .002 .0015 .0015 .0015	No. 3 Slit Edges Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi	lerances ing 1 1/2" wide	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002)	igth
	.040049 .035039 .029034 .020028 .017019 .013016 .011012 .010010 .005000 .004004	Width 1/8" to 6" incl. +/- 9 .002 9 .0015 9 .0015 9 .001 9 .001 9 .001 9 .001 9 10% auge control allo	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .0011 .001 .001 .001	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0015	Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi Over 1 1/2" to 24 Chamber is the gree	lerances ing 1 1/2" wide l: exclusive eatest deviation of a	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002) 1/2" in an 8' len 1/4" in an 8' ler	igth igth straight line,
	.040049 .035039 .029034 .020028 .017019 .013016 .011012 .010010 .005000 .004004	Width 1/8" to 6" incl. +/- 9 .002 9 .0015 9 .0015 9 .001 9 .001 9 .001 9 .001 9 .001 9 .001 9 .001 9 .001	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .0011 .001 .001 .001	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0015	Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi Over 1 1/2" to 24 Chamber is the gree	lerances ing 1 1/2" wide l: exclusive eatest deviation of a	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002) 1/2" in an 8' len 1/4" in an 8' len	igth igth straight line,
	.040049 .035039 .029034 .020028 .017019 .013016 .011012 .010010 .005000 .004004	Width 1/8" to 6" incl. +/- 9 .002 9 .0015 9 .0015 9 .001 9 .001 9 .001 9 10% 9 10% auge control allohan those shown	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .0011 .001 .001 .001	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0015	No. 3 Slit Edges Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi Over 1 1/2" to 24 Chamber is the grethe measurement b	lerances ing 1 1/2" wide l: exclusive eatest deviation of a eing taken on the co	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002) 1/2" in an 8' len 1/4" in an 8' ler a side edge from a s ncave side with a stra	igth igth straight line,
	.040049! .035039! .029034! .020028! .017019! .013016! .011012! .010010! .005000! .004004!	## Width ## 1/8" to 6" ## incl. +/- ## .002 ## .002 ## .0015 ## .001 ## .002 ## .003 #	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .001 .001 .001 .001 .	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0015 .0016	Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi Over 1 1/2" to 24 Chamber is the gre the measurement b	lerances ing 1 1/2" wide l: exclusive eatest deviation of a leing taken on the col	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002) 1/2" in an 8' len 1/4" in an 8' ler a side edge from a s ncave side with a stra	ngth ngth straight line, aight line.
STEEL STRIP	.040049 .035039 .029034 .020028 .017019 .013016 .011012 .010010 .005000 .004004	Width 1/8" to 6" incl. +/- 9 .002 9 .0015 9 .0015 9 .001 9 .001 9 .001 9 10% 9 10% auge control allohan those shown	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .0011 .001 .001 .001	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0015	No. 3 Slit Edges Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi Over 1 1/2" to 24 Chamber is the grethe measurement b	erances ing 1 1/2" wide i: exclusive eatest deviation of a eing taken on the con	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002) 1/2" in an 8' len 1/4" in an 8' ler a side edge from a s ncave side with a stra	ngth ngth straight line, aight line.
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STEEL STRIP STAINLESS	In Inches .040049! .035039! .029034! .020028: .017019! .013016: .011012: .005000! .004004! Automatic g tolerances ti Thickn Gauge	## Width ## 1/8" to 6" ## incl. +/- 9	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .001 .001 .001 .001 .	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0015 .0015 .0016 .0016 .0016 .0010 .0010 .0010 .0010 .0010 .0010 .002 .002	Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi Over 1 1/2" to 24 Chamber is the grethe measurement b Width Tolera Thickness / Wi Under .1874 / to Under .1874 / to	lerances ing 1 1/2" wide l: exclusive eatest deviation of a eing taken on the con ances (inches) idth / Length 48" / to 120" 48" / over 120"	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002) 1/2" in an 8' len 1/4" in an 8' len a side edge from a s neave side with a stra	ngth ngth straight line, aight line. Length (+1/4 - 0) (+1/2 - 0)
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STEEL STRIP STAINLESS	In Inches .040049! .035039! .029034! .020028! .017010! .013016! .011012! .010000! .004004! Automatic g tolerances ti Thickn Gauge 19 20 21 22 23 24 25 26	Width 1/8" to 6" incl. +/- 9 .002 9 .0015 9 .0015 9 .001 9 .001 9 .001 9 .001 9 .001 Auge control allohan those shown ESS Toleran Normal Decimal .0400459 .0350399 .0320349 .0290319 .0260289 .0230259 .0200229 .0180199	6" to 12" incl. +/003 .002 .002 .0015 .0015 .0015 .001 .001 .001 .006 .008 .008 .009 .009 .009 .009 .009 .009	incl. +/003 .002 .002 .0015 .0015 .0015 .0015 .0016 10% Plue /Minus .003 .002 .002 .002 .002 .002 .0015 .0015 .0015	Width (Inches) .187 to .500 .500 to 6 Over 6 to 9 Over 9 to 12 Over 12 to 20 Over 20 to 23.99 Chamber Tol Up to and includi Over 1 1/2" to 24 Chamber is the greathe measurement by Width Tolera Thickness / Wi Under .1874 / to Under .1874 / to Chamber Tol Specified in inch 24 - 36 inches (ir Over 36 Chamber is the greather to the measurement by	lerances ing 1 1/2" wide le exclusive eatest deviation of a leing taken on the col ances (inches) dth / Length 48" / to 120" 48" / over 120" lerances includes 36) reatest deviation of a	Thickness (inch (+ /005) (+ /005) (+ /005) (+ /001) (+ /0016) (+ /002) 1/2" in an 8' len 1/4" in an 8' len a side edge from a s neave side with a stra Width (+ 1/16 - 0) (+ 1/16 - 0) Variation in incunit length of 8 .1250 .0938	ngth hothingth line, aight line. Length (+1/4 - 0) (+1/2 - 0) ches per 3 feet
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OUR COMMITMENT

We value our customers and always will be a customer-driven company.

ESM strives to stay competitive by understanding our customers' needs, constantly innovating our process, and continually improving our ability to deliver the quality products our customers demand which allows us to continue to be the best-in-class.





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Certifications