

Crafting Brilliance, Inspiring Excellence in Steel Tube

# GREEN MANUFACTURING BUILDS A LOW-CARBON WORLD

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ONE-STOP PROVIDER FOR PRECISION STEEL  
TUBE AND TUBE PROCESSING SOLUTIONS



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WEBSITE

HEBEI CBIES AUTOMOTIVE PARTS CO., LTD.





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## COMPANY PROFILE

CBIES is a leading manufacturer of precision tubes in China, specializing in the designing, manufacturing and after-sales maintenance for precision tubes and parts with an 18-year track record of excellence. We excel in precision tube for diverse applications across automotive, motorcycle, machinery and medical instruments.

With a truly global footprint, our markets reach far and wide to serve customers in North America, Central and South America, the European Union, Southeast Asia, Central Asia, and beyond. And our portfolio encompasses hot rolled welded tube, cold rolled welded tubes, cold drawn welded tubes, precision seamless steel tubes and heat-treated steel tubes.

We are steadfastly devoted to delivering premium quality products and services to our esteemed clientele. Upheld by certifications such as IATF16949:2016, ISO 9001:2015, ISO14001:2015, and ISO45001:2018, we have meticulously constructed a stringent internal management framework. This system guarantees that all our products and services consistently meet international standards and exceed customer expectations.



# CBIES INTRODUCTION

## CORE VALUES

### QUALITY

Our QC inspectors monitor the entire process of each order, from raw materials, samples, production, packaging, warehousing to container loading, to ensure that product quality fully meets market and customer requirements.

### HONESTY

Honesty is essential in all long term cooperation and partnership. We believe in being open and transparent in all transactions and always act with integrity.

### SERVICE

We prioritize customer needs and are committed to providing excellent service. We are customer centric, market oriented, and we always strive to exceed customer expectations.

### SPECIALITY

Professional skills are the foundation of excellent service. Our professional and dedicated team members make our customers' business easier and safer.

### CREATIVITY

We embrace innovation and creativity, and are committed to building a digital ecosystem to meet the evolving needs of customers and empowering them with new opportunities.

## VISION

To build a lighter, safer, greener and better world. We are committed to continuous innovation and improvement.

## MISSION

Crafting Brilliance,  
Inspiring Excellence  
in Steel Tube.

## SOCIAL RESPONSIBILITY

CBIES takes "Green Manufacturing Makes A Low-Carbon World" as its slogan, and proactively paves the way for it. CBIES also invests in a digital administration system and creates shared value together with its stakeholders.

### DEVELOPING A SUSTAINABILITY MANAGEMENT

To upgrade the digital management system, CBIES integrated ERP and OA system in 2020 so that our daily work becomes more efficient with less paper usage.

### ENCOURAGING EMPLOYEE ENGAGEMENT

The company ensures a clear delineation of job responsibilities, competency standards, compensation criteria and employee handbook policies. This commitment to clarity in roles and expectations, along with competitive compensation, aims to foster a conducive environment for professional growth and job satisfaction among the employees.

### PROTECTING FEMALE EMPLOYEE

Currently, there are **96** female employees(**46%**) on staff. We ensure equal opportunities for female employees in terms of promotions, compensation, and project allocations, actively avoiding gender discrimination.

### SUPPORTING LOCAL COMMUNITIES

Since 2011, an annual donation of **100,000 RMB** in hardware teaching equipment and educational funds has been made to impoverished schools and students in mountainous areas every June. This initiative has been sustained for **13 years**. By adopting sustainable development practices, CBIES not only reduces the environmental impact but also improves our reputation, attracts customers and investors who value sustainability, and creates a more resilient and profitable business model for the future.



# FOOTPRINT

## 2006

In 2006, the steel tube plant was built and put into full operation with a monthly production capacity of **20,000** tons.

## 2013

In 2013, the high precision tube welding project was put into operation.

## 2015

In 2015, CBIES's own supply chain system was established, including storage, logistic and transportation.

## 2016

In 2016, the "CBIES" auto parts international brand was registered in **EU and Southeast Asia** countries.



## 2018

In 2018, products entered into the **North America, Central and South America and Southeast Asia** markets.

## 2023

The CBIES Automotive was updated to new design.



The "CBIES" brand was updated and registered, which signified that CBIES entirely went into more industries, such as **Machinery, Motorcycle, Medical instrument, Aerospace, Sport instrument, Gas instrument.**



## 2012

In 2012, the precision tube factory was built and put into operation.

## 2014

In 2014, introduced in the South Korea's KTM welding tube production line, **Handuk** anaerobic annealing production line, drawing production line, quenching and tempering production line and put into operation.

## 2017

In 2017, the semi-finished auto parts factory was founded and started production.

## 2020

In 2020, the entire supply chain digital system of CBIES started to be put into use and operation.

## 2024

CBIES has officially established the ESG Committee.

# SUPPLY CHAIN MANAGEMENT SYSTEM

## PRODUCTION EQUIPMENTS



Korean KTM high-frequency welded tubes production line



Fully automatic high frequency induction quenching/straightening production line for side door impact beam



Korean Handuk roller hearth type continuous anaerobic annealing furnace



Korean triple drawing bench



Tube bending machine(Taiwan)



Punching machine

# SUPPLY CHAIN MANAGEMENT SYSTEM

## QUALITY MANAGEMENT SYSTEM



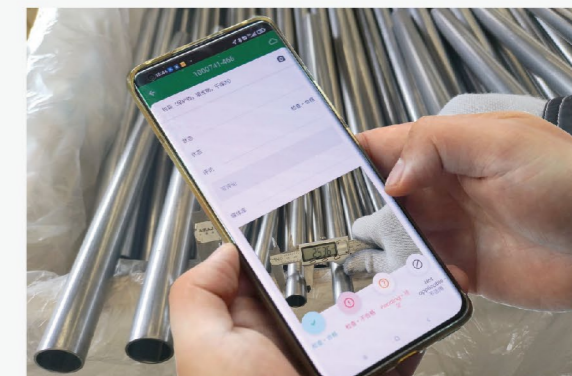
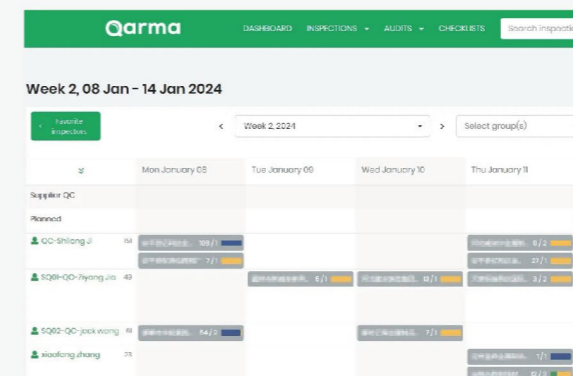
IATF16949:2016 certificate



CBIES has established a comprehensive quality management system, which includes a series of quality certification, a variety of testing equipment with the corresponding tests, and the digital quality inspection tool QARMA.

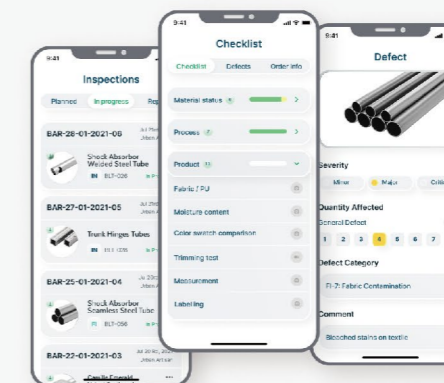
We already have IATF16946:2016, ISO9001:2015, ISO45001:2018, ISO14001:2015.

## QARMA SYSTEM



### PLANNING & SCHEDULING FOR INSPECTOR

### GIVE REPORTS & ANALYTICS & INSIGHTS



### COVER EVERY STEP OF INSPECTION PROCESS

The digital quality inspection tool QARMA, adopted by CBIES, enhances its ability to maintain and uphold the highest standards across all stages of production.

# SUPPLY CHAIN MANAGEMENT SYSTEM

## TESTING EQUIPMENTS

CBIES has meticulously implemented a holistic quality management system. This robust framework is fortified by a diverse portfolio of precision testing equipment, each designed to conduct the corresponding tests necessary for ensuring product excellence.

- ⊙ Universal material tester
- ⊙ Metallographic microscope
- ⊙ HB/HRC(HRB)/HV hardness tester
- ⊙ Rockwell Hardness tester
- ⊙ Roughness tester
- ⊙ Metallographic specimen grinder
- ⊙ Straightness tester
- ⊙ Eddy current testing instrument
- ⊙ Stamping test machine
- ⊙ Expansion test machine
- ⊙ Bend tester



## STORAGE AND LOGISTIC

CBIES places great emphasis on quality control throughout the entire packaging and transportation process. Our storage team carefully inspects each product before packaging to ensure that it is in good condition and ready for transportation.

CBIES strictly adheres to the international packaging standards in order to ensure the safety of the products and reduce the possibility of damage during transportation. And all the packaging materials are recyclable and eco-friendly to help minimize the environmental impact.

We offer customized packaging services to meet the specific needs of our customers, including customized product labels, markings, folding and packaging services to make it

easier to identify and manage inventory. And we provide comprehensive transportation services to ensure timely and accurate delivery of products.

Door-to-door services don't stop at the harbour. CBIES has its own logistics department and freight forwarder which set up an efficient logistics infrastructure and organization in most of the global markets.

Our scale and presence creates cost efficiencies in intercontinental shipping as well as local customs clearing, warehousing and road transportation services. We take care of the last-mile logistics, and can invoice on DDP basis and also provide 3PL(third party logistics) services.





# PRODUCTS AND APPLICATIONS

## HOT/COLD ROLLED WELDED TUBES

### - Advantages

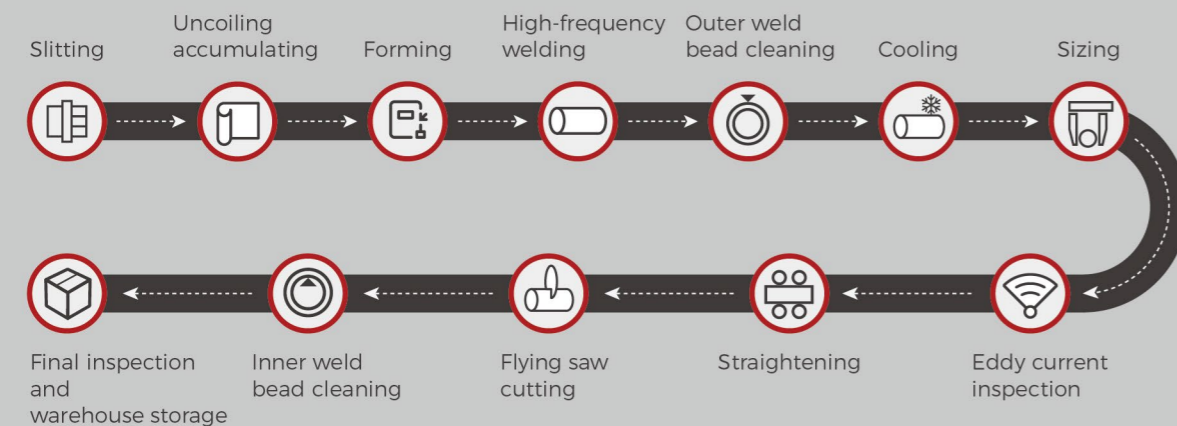
- **Equipment:** KTM welding production line with consistent high-precision weld joint height and accommodates necking or expansion processes with a maximum deformation limit of 45%.
- **Internal tube weld joint residual height:** Below 0.1 mm.
- **Tolerance:** Outer diameter tolerance is  $\pm 0.05\text{mm}$ , ellipticity is  $\pm 0.03\text{mm}$ .
- We are skilled in special-shaped tubes and high-strength steel precision tubes.



### - Standards and Specifications

- **Round tubes outer diameter :** 8-127mm.
- **Rectangular tubes:** 6x6-100x100mm, 6x10-90x130mm.
- Standards and more specifications information refer to page 25-28.

**- Applications:** Automotive seat frame, cross car beam, chassis parts, motorcycle frame, rear frame, carrier front, exercises machines, machinery, medical & healthcare equipment, etc.



## COLD DRAWN WELDED TUBES

### - Advantages

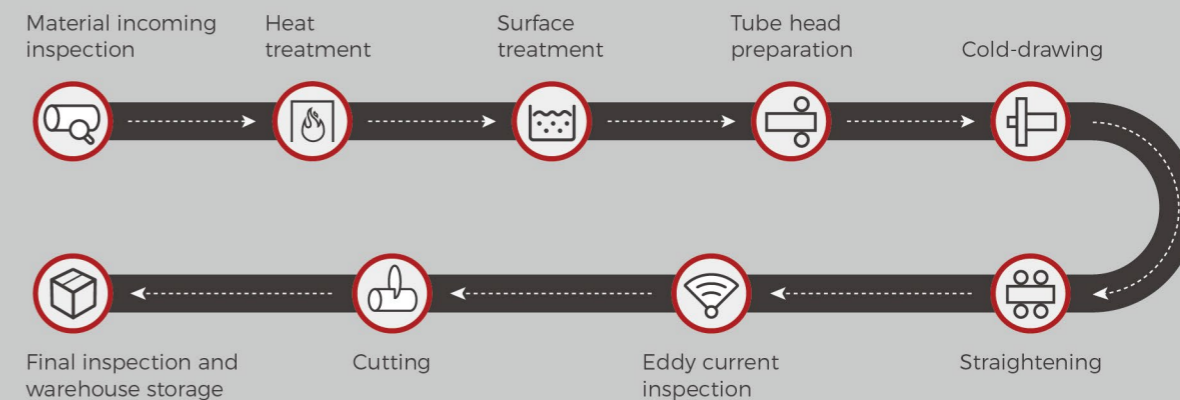
- **Equipment:** Triple-line drawn machine unit.
- **Interior surface roughness:** Within  $Ra \leq 0.4\mu\text{m}$ .
- **Tolerance:** Outer diameter tolerance is  $\pm 0.03\text{mm}$ .
- **Tube straightness:** Within 0.5 mm/meter.
- We are skilled in special-shaped tubes and high-strength steel precision tubes.



### - Standards and Specifications

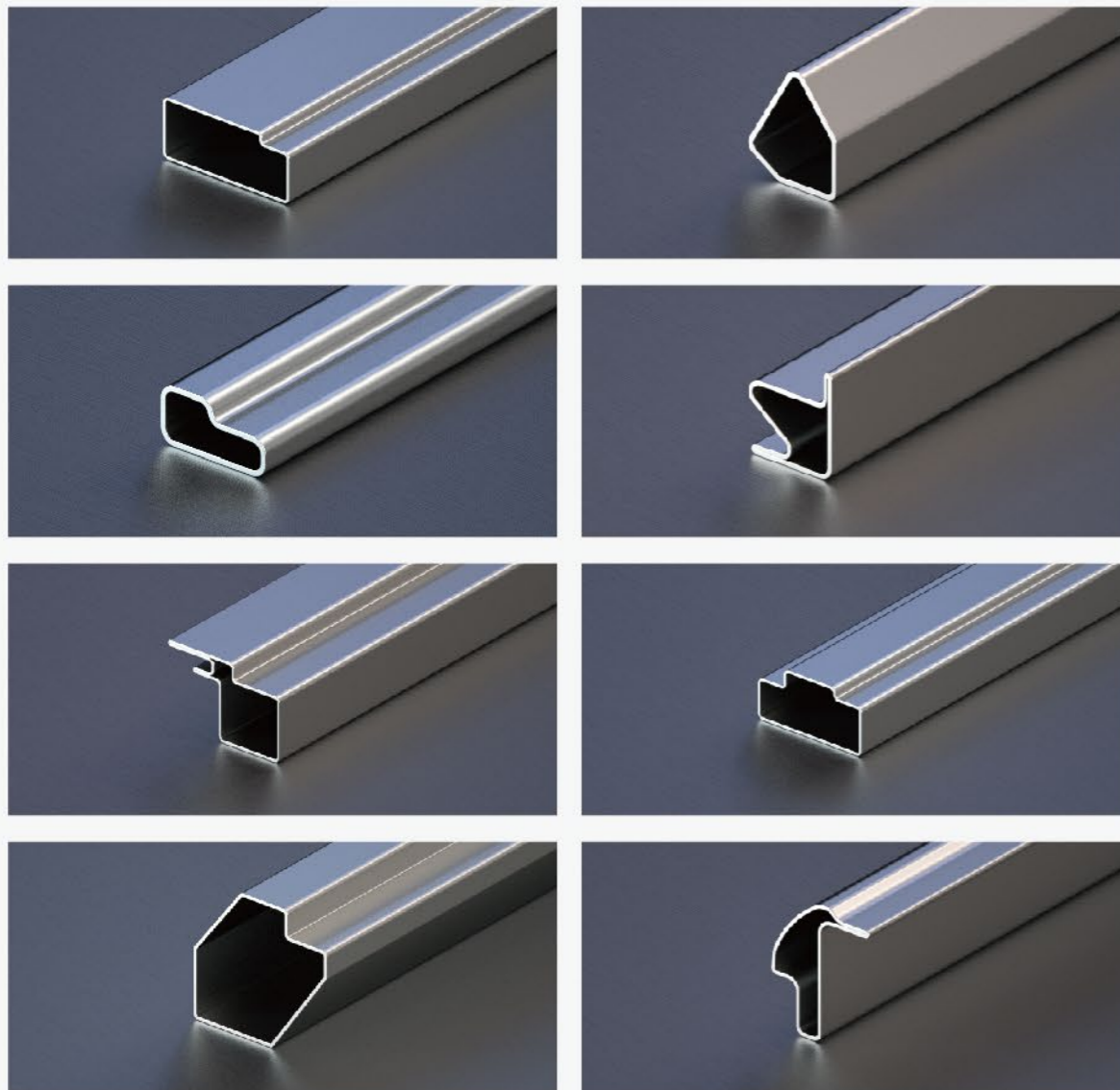
- **Round tubes outer diameter:** 8-127mm.
- Standards and more specifications information refer to page 25-28.

**- Applications:** Automotive shock absorber, headrest tube, gas spring, gas cylinder, costly furniture, motorcycle and electric vehicle shock absorber, and other precision parts.

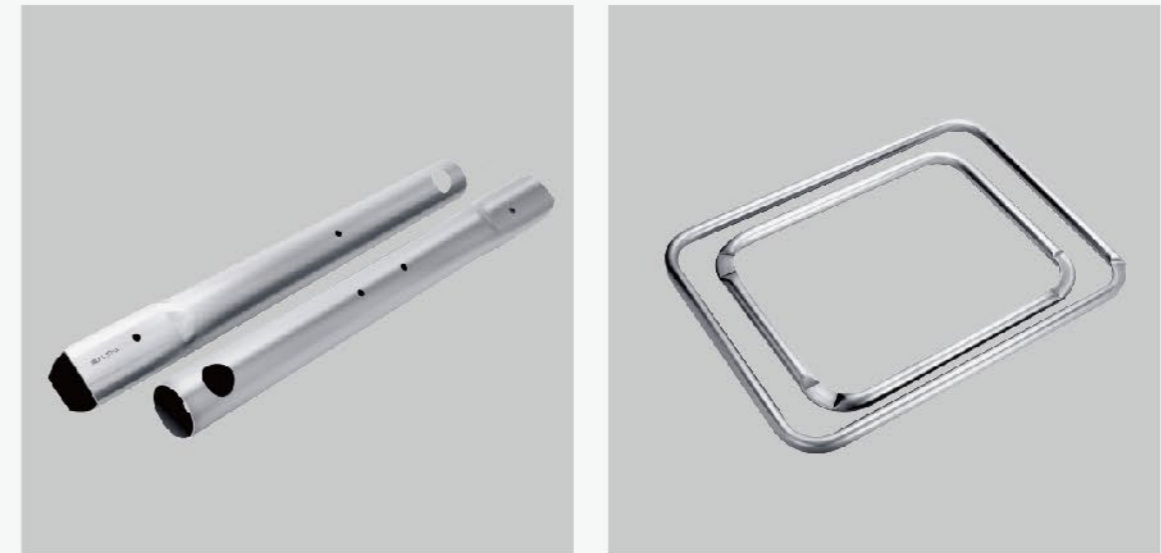


## SPECIAL-SHAPED TUBES

CBIES incorporates strip steel cold bending forming, round tube cold bending forming and drawn forming techniques into its process design, thereby catering to the customization needs according to customer requirements.



## HIGH-STRENGTH STEEL PRECISION TUBES



### - ADVANTAGES

- CBIES boasts extensive experience in the production of high-strength steel precision tube, and covers a range of grades such as HC550/980DP, BR1200HS, BR1500HS, S550MS, 500/780DP and CR1300T/1030Y, etc.
- With a view to meet lightweight requirements, we have designed and optimized the production lines that feature both high strength and precision.
- We maintain close collaboration with major Chinese steel mills to supply high-strength steel raw materials that conform to a variety of stringent production standards.

# PRODUCTS AND APPLICATIONS

## HEAT-TREATED STEEL TUBES

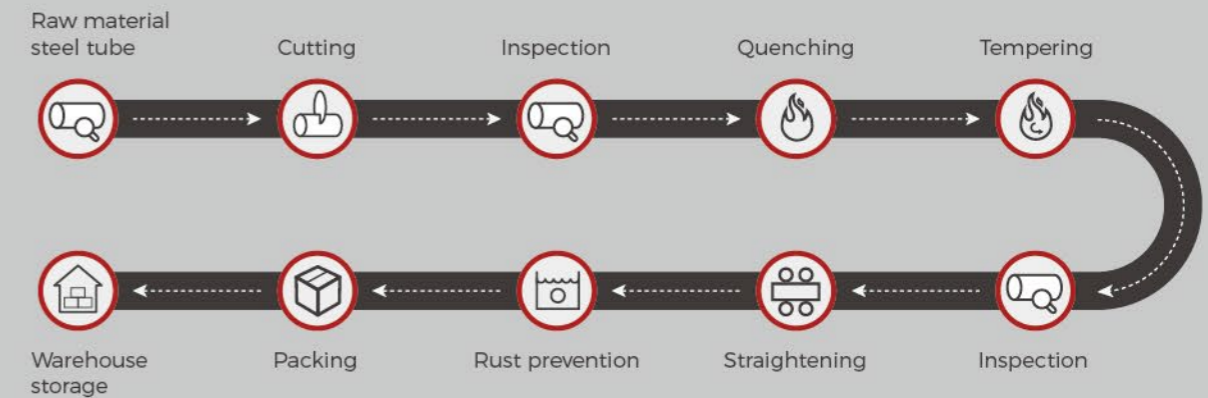
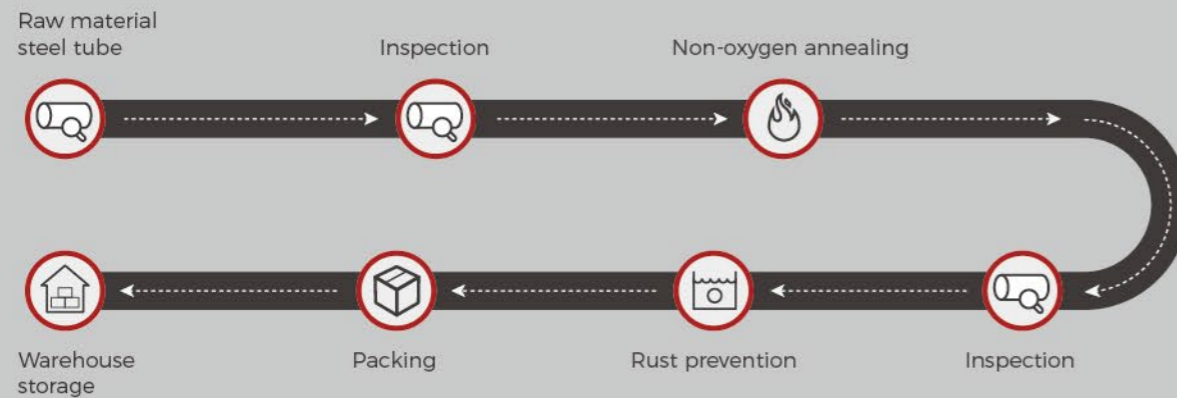
### - Advantages

- **Equipment:** Korean Handuk anaerobic annealing and roll-bottom annealing equipment.
- Efficient annealing process.
- Substantial production capacity.
- Superior surface finish.



### - Advantages

- **Equipment:** Automatic high-frequency quenching and straightening line.
- **Material:** BR1500HS hot-formed steel.
- **Mechanical properties:** Tensile strength can reach up to 1,500MPa, and yield strength can reach up to 1,200MPa.
- **Heat Treatment Condition:** Quenching+tempering, annealing, normalizing.

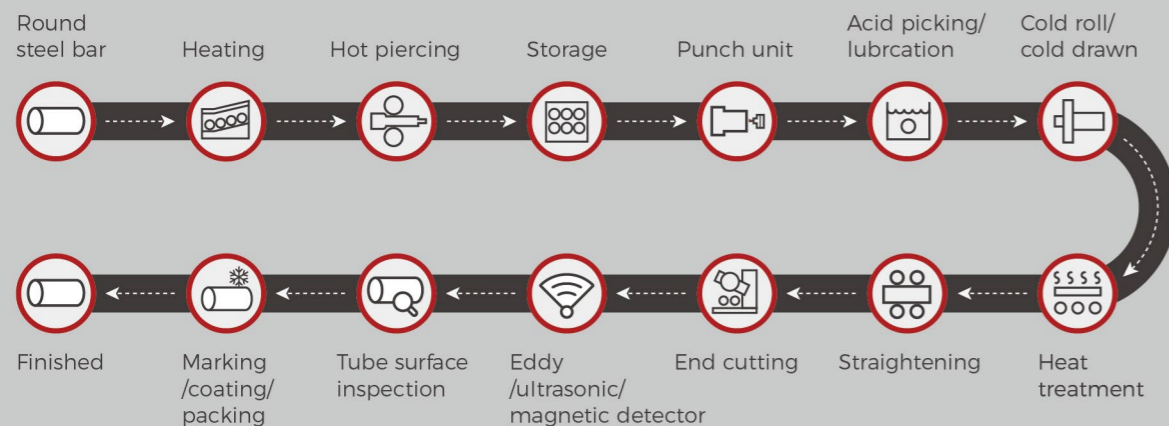


# PRODUCTS AND APPLICATIONS

## PRECISION SEAMLESS STEEL TUBES



- **OD:** 6-400mm
- **Thickness:** 0.8-30mm
- **Standard:** EN10305-1,EN10305-4,DIN2391,ASTM A519,GB/T3639.
- **Materials:** E215,E355,ST35,ST45,ST52,4130,4140,10,20,35,45
- **Delivery Condition:** Cold drawn,cold drawn and stress released,normalizing,annealed.
- **ID Tolerance:** H8-H9
- **Straightness:** 0.2-0.5mm/m
- **Inner Roughness:** Ra0.2-0.8 $\mu$ m
- **Processing Method:** Cold rolling, cold drawn-honed, deep hole boring-honed, deep hole boring-roll.
- **Applications:** Automotive side impact beam, bush, spring holder, hydraulic cylinders, pneumatic cylinders,mechanical structure. Customers' special requirement will be upon discussion.



## OTHER TUBES



ALUMINUM COATED PIPE



GALVANIZED TUBE



THERMAL RADIATION TUBE



ALUMINUM-MAGNESIUM-ZINC COATED TUBE



STAINLESS STEEL PIPE



ALUMINUM TUBE

# PRODUCTS AND APPLICATIONS

## PROCESSING AFTER TUBE MAKING



Tube welding



Tube flattening



Tube necking



Tube hydro-bugling



Tube bending



Tube cutting



Tube punching



Tube champering



Tube laser cutting



Tube stamping ring



Tube flaring



Tube pneumatic engraving

### AUTOMOTIVE PARTS



Trunk trim bracket



Retaining ring



Bushing



Suspension mounting string



Suspension part



Striker hook



Subframe spacer



Subframe tube



Seat adjuster tube



Cross car beam



Handrest tube



PDU support part

### MOTORCYCLE PARTS



Handle bar



Upright handle bar



Luggage carrier



Motorcycle rear shelf



Trunk support tube



Rear rack



Left/right pedal



Lamp frame tube

### GAS PIPE



Gas pipe

### TRUCK PARTS



Truck pedal tube

### RECREATIONAL BIKE PARTS



Side vertical tube

### MACHINERY PARTS



Adjuster tube

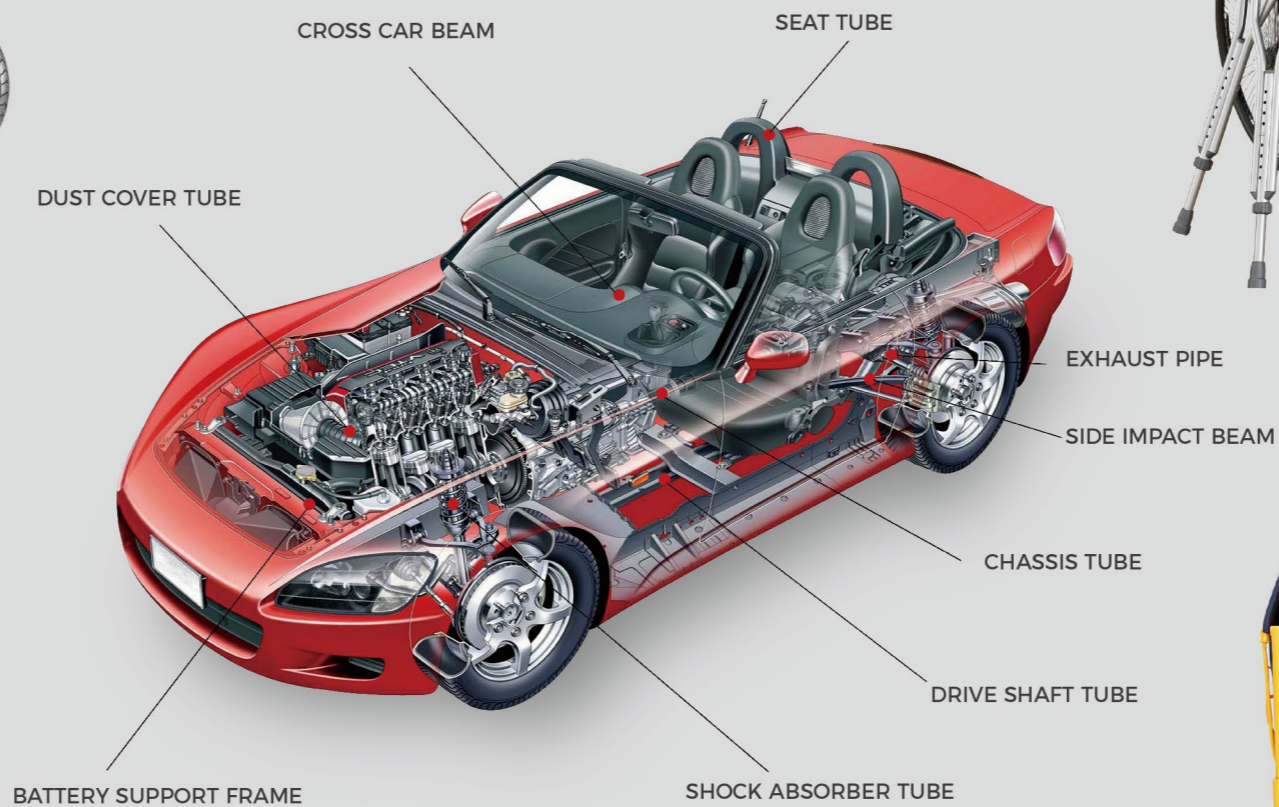
# PRODUCTS AND APPLICATIONS

## APPLICATIONS

### MOTORCYCLE PARTS



### AUTOMOTIVE PARTS



### MEDICAL AND HEALTHCARE PARTS



### RECREATIONAL BIKE PARTS



### MACHINERY PARTS



# PRODUCTION STANDARDS

| STANDARD   | MATERIAL   | STANDARD TITLE   |
|------------|--|--|
| GB/T 13793 | Q195, Q215, Q235, Q275, Q345B(Q355B), Q390, Q420, Q460                         | Steel pipes with a longitudinal electric (resistance) weld   |
| GB/T 3639  | 10, 20, 35, 45, Q345B(Q355B)   | Seamless cold-drawn or cold-rolled steel tubes for precision applications  |
| EN 10305-1 | E215, E235, E275, E355   | Steel tubes for precision applications - Technical delivery conditions - Part 1: Seamless cold drawn tubes   |
| EN 10305-2 | E215, E235, E275, E355   | Steel tubes for precision applications - Technical delivery conditions - Part 2: Welded cold drawn tubes   |
| EN 10305-3 | E215, E235, E275, E355   | Steel tubes for precision applications - Technical delivery conditions - Part 3: Welded cold sized tubes   |
| EN 10305-4 | E215, E235, E275, E355   | Steel tubes for precision applications - Technical delivery conditions - Part 4: Seamless cold drawn tubes for hydraulic and pneumatic power systems |
| EN 10305-5 | E215, E235, E275, E355   | Steel tubes for precision applications - Technical delivery conditions - Part 5: Welded cold sized square and rectangular tubes                      |
| DIN 2391-1 | St 30 Si, St 30 Ai, St 35, St 45, St 52  | Seamless precision steel tubes - Part 1: Dimensions  |
| DIN 2391-2 | St 30 Si, St 30 Ai, St 35, St 45, St 52  | Seamless precision steel tubes - Part 2: Technical delivery conditions   |
| DIN 2393-2 | RSt 34-2, RSt 37-2, ST 44-2, ST 52-3   | Welded precision steel tubes - Part 2: Technical delivery conditions   |
| DIN 2394-1 | RSt 34-2, RSt 37-2, ST 44-2, ST 52-3   | As-welded and sized precision steel tubes - Part 1: Dimensions   |
| DIN 2394-2 | RSt 34-2, RSt 37-2, ST 44-2, ST 52-3   | As-welded and sized precision steel tubes - Part 2: Technical delivery conditions  |
| ASTM A519  | 1008, 1010, 1012, 1015, 1018, etc  | Standard Specification for Seamless Carbon and Alloy Steel Mechanical Tubing   |
| ASTM A 513 | 1008, 1010, 1012, 1015, 1018, etc  | Standard Specification for Electric-Resistance-Welded Carbon and Alloy Steel Mechanical Tubing   |
| JIS-G 3445 | STKM11, STKM12, STKM13, STKM14, STKM15, STKM16, STKM17, STKM18, STKM19, STKM20 | Carbon steel tubes for mechine structural purposes   |

# PRODUCT SPECIFICATIONS

| TYPE                        | SPECIFICATION |           |           |            |            |            |            |           |           |             |            |  | UNIT: MM |
|-----------------------------|---------------|-----------|-----------|------------|------------|------------|------------|-----------|-----------|-------------|------------|--|----------|
| <b>ROUND TUBE</b><br>       | 8.00          | 9.50      | 10.00     | 11.00      | 11.85      | 12.30      | 12.70      | 13.00     | 13.50     | 14.00       | 15.00      |  |          |
|                             | 15.90         | 16.00     | 17.50     | 18.00      | 18.30      | 19.00      | 19.20      | 19.40     | 20.00     | 20.50       | 21.00      |  |          |
|                             | 21.30         | 21.50     | 22.20     | 23.42      | 23.70      | 24.70      | 25.00      | 25.40     | 26.00     | 26.75       | 27.00      |  |          |
|                             | 27.50         | 28.00     | 28.20     | 28.60      | 30.00      | 30.80      | 31.80      | 32.35     | 32.95     | 33.30       | 34.00      |  |          |
|                             | 35.00         | 35.50     | 37.00     | 38.10      | 40.00      | 42.00      | 42.70      | 43.50     | 44.50     | 45.00       | 47.00      |  |          |
|                             | 47.60         | 48.60     | 49.30     | 50.00      | 50.80      | 51.20      | 55.00      | 57.00     | 60.00     | 61.00       | 63.50      |  |          |
|                             | 70.00         | 72.00     | 75.00     | 76.20      | 80.00      | 87.50      | 89.00      | 125.00    | 127.00    |             |            |  |          |
| <b>SQUARE TUBE</b><br>      | 7.6*7.6       | 9*9       | 10*10     | 12.7*12.7  | 13*13      | 15*15      | 16*16      | 18*18     | 19*19     | 19.5*19.5   | 20*20      |  |          |
|                             | 20.5*20.5     | 21*21     | 21.4*21.4 | 22*22      | 25*25      | 25.4*25.4  | 28.6*28.6  | 30*30     | 31*31     | 31.75*31.75 | 33*33      |  |          |
|                             | 35*35         | 38*38     | 40*40     | 44.5*44.5  | 45*45      | 48*48      | 50*50      | 50.8*50.8 | 57.4*57.4 | 60*60       | 64*64      |  |          |
|                             | 65*65         | 70*70     | 75*75     | 76.2*76.2  | 90*90      | 100*100    |            |           |           |             |            |  |          |
| <b>RECTANGULAR TUBE</b><br> | 6*10          | 8*16      | 8*20      | 8.9*34.3   | 9.5*38.1   | 10*16      | 10*17.8    | 10*20     | 10*30     | 12*22       | 12.5*25    |  |          |
|                             | 12.7*25.4     | 12.7*31.8 | 12.7*38.1 | 12.7*50.8  | 13*19      | 13*26      | 14*20      | 14*21     | 14*24     | 14*32       | 15*25      |  |          |
|                             | 15*30         | 15.5*34.5 | 15.8*41.3 | 16*40      | 16.8*42.3  | 17*34      | 17*42      | 18.3*56.2 | 19*38     | 19.05*31.75 | 19.05*38.1 |  |          |
|                             | 20*30         | 20*35     | 20*40     | 20*50      | 20*60      | 20*75      | 20.3*58.2  | 21.8*47.2 | 22*32     | 23*53       | 25*30      |  |          |
|                             | 25*35         | 25*38     | 25*40     | 25*50      | 25.4*38.1  | 25.4*50.8  | 25.4*70    | 25.4*76.2 | 26*50     | 27*80       | 29.5*80    |  |          |
|                             | 30*40         | 30*50     | 30*55     | 30*60      | 30*70      | 30*80      | 30*90      | 31.8*50.8 | 35*57     | 35*70       | 35*130     |  |          |
|                             | 38*89         | 38*58     | 38.1*50.8 | 38.1*63.5  | 38.1*88.9  | 38.1*76.2  | 38.1*101.6 | 40*60     | 40*70     | 40*80       | 40*100     |  |          |
|                             | 41.5*48       | 41.5*50.8 | 44.5*50.8 | 44.5*69.85 | 45*75      | 44.5*101.6 | 50*75      | 50.8*76.2 | 50*80     | 50*100      | 60*120     |  |          |
|                             | 63.5*88.9     | 90*130    |           |            |            |            |            |           |           |             |            |  |          |
| <b>FLAT OVAL TUBE</b><br>   | 10*24         | 10*25     | 11*22     | 12*18      | 13*36      | 15*26      | 15*30.5    | 15*50     | 15.5*44.5 | 15.5*45     | 16*35      |  |          |
|                             | 17*40.1       | 20*40     | 20*60     | 20*100     | 20*140     | 24.9*76.2  | 28*58      | 30*60     | 30*70     | 40*80       | 40*100     |  |          |
|                             | 40*137        | 41.6*70   | 50*100    | 50*110     | 31.8*50    | 62.5*87.5  | 30*40      | 18*30     |           |             |            |  |          |
| <b>OVAL TUBE</b><br>        | 9*16          | 10*17     | 15*30     | 20*35      | 35.15*63.1 | 50*100     |            |           |           |             |            |  |          |

Thickness:0.6-5.0MM

Length:50-12000MM.

Specifications can be customized according to customer requirements.