



ABBHEY INTERNATIONAL LTD.

TUBE & PIPE MILL DESIGNATIONS

Inch Measurements

Revision 04/06

| MILL DESIGNATION NUMBER | TUBE SIZE RANGE | | | | OPTIONS |
|-------------------------|-----------------|-------|-------|-------|-------------|
| | O.D. | | WALL | | |
| | MAX. | MIN. | MAX. | MIN. | |
| 00K - .500 | 0.500 | 0.188 | 0.035 | 0.013 | IS |
| 0K - .750 | 0.750 | 0.250 | 0.065 | 0.013 | IS |
| 1X - 1.0 | 1.000 | 0.375 | 0.065 | 0.018 | IS |
| 1K - 1.5 | 1.500 | 0.375 | 0.083 | 0.018 | IS |
| 1KH - 1.5 | 1.500 | 0.375 | 0.134 | 0.020 | IS |
| 2X - 2.0 | 2.000 | 0.437 | 0.095 | 0.020 | IS |
| 2X - 2.25 | 2.250 | 0.500 | 0.095 | 0.020 | IS |
| 2K - 2.5 | 2.500 | 0.500 | 0.125 | 0.028 | IS, DS |
| 2K - 3.0 | 3.125 | 0.625 | 0.134 | 0.028 | IS, DS |
| 2K - 3.5 | 3.687 | 0.625 | 0.125 | 0.028 | IS, DS |
| 2K - 4.0 | 4.000 | 0.840 | 0.090 | 0.028 | IS, DS |
| 3X - 2.5 | 2.500 | 0.675 | 0.160 | 0.032 | IS, DS |
| 3X - 3.0 | 3.000 | 0.700 | 0.160 | 0.032 | IS, DS, TBS |
| 3X - 3.5 | 3.500 | 0.750 | 0.160 | 0.032 | IS, DS, TBS |
| 3X - 4.0 | 4.000 | 0.840 | 0.154 | 0.032 | IS, DS, TBS |
| 3KL - 3.0 | 3.000 | 0.840 | 0.180 | 0.035 | DS |
| 3K - 3.0 | 3.000 | 0.840 | 0.220 | 0.042 | DS |
| 3K - 3.5 | 3.500 | 0.840 | 0.203 | 0.042 | DS |
| 3KH - 3.5 | 3.500 | 0.840 | 0.250 | 0.042 | DS |
| 3K2H - 3.5 | 3.500 | 0.840 | 0.354 | 0.042 | DS |
| 4XL - 4.5 | 4.500 | 1.000 | 0.160 | 0.032 | IS, DS, TBS |
| 4XL - 5.0 | 5.000 | 1.250 | 0.160 | 0.032 | IS, DS, TBS |
| 4X - 4.5 | 4.500 | 1.000 | 0.188 | 0.042 | DS, TBS |
| 4X - 5.0 | 5.000 | 1.250 | 0.188 | 0.042 | DS, TBS |
| 4K - 4.5 | 4.500 | 1.000 | 0.250 | 0.049 | DS, TBS |
| 4KH - 4.5 | 4.500 | 1.000 | 0.338 | 0.083 | DS, TBS |
| 4K2H - 4.5 | 4.500 | 1.500 | 0.437 | 0.120 | DS |
| 5KL - 5.0 | 5.000 | 1.250 | 0.220 | 0.049 | DS, TBS |
| 5K - 5.625 | 5.625 | 1.250 | 0.250 | 0.049 | DS, TBS |
| 5KH - 5.0 | 5.000 | 1.500 | 0.312 | 0.083 | DS |
| 5KH - 5.625 | 5.625 | 1.500 | 0.375 | 0.083 | DS |
| 5K2H - 5.625 | 5.625 | 2.375 | 0.437 | 0.120 | DS |
| 5K3H - 5.625 | 5.625 | 2.500 | 0.500 | 0.120 | DS |

| MILL DESIGNATION NUMBER | TUBE SIZE RANGE | | | | OPTIONS |
|-------------------------|-----------------|--------|-------|-------|---------|
| | O.D. | | WALL | | |
| | MAX. | MIN. | MAX. | MIN. | |
| 6X - 6.625 | 6.625 | 1.900 | 0.237 | 0.049 | DS, TBS |
| 6KL - 6.625 | 6.625 | 1.900 | 0.280 | 0.065 | DS, TBS |
| 6K - 6.625 | 6.625 | 1.900 | 0.338 | 0.083 | DS, TBS |
| 6KH - 6.625 | 6.625 | 2.375 | 0.437 | 0.120 | DS |
| 6K2H - 6.625 | 6.625 | 2.500 | 0.500 | 0.120 | DS |
| 6K3H - 6.625 | 6.625 | 3.000 | 0.630 | 0.120 | DS |
| 7XL - 7.5 | 7.500 | 2.375 | 0.188 | 0.042 | DS, TBS |
| 7X - 7.5 | 7.500 | 2.375 | 0.280 | 0.065 | DS, TBS |
| 7K - 7.5 | 7.500 | 2.375 | 0.340 | 0.083 | DS, TBS |
| 8X - 8.75 | 8.750 | 2.875 | 0.322 | 0.083 | DS, TBS |
| 8K - 8.75 | 8.750 | 2.875 | 0.375 | 0.083 | DS, TBS |
| 8KH - 8.75 | 8.750 | 3.000 | 0.500 | 0.120 | DS, TBS |
| 8K2H - 8.75 | 8.750 | 3.000 | 0.630 | 0.120 | DS |
| 10K - 10.75 | 10.750 | 3.000 | 0.500 | 0.120 | DS, TBS |
| 12X - 12.75 | 12.750 | 3.500 | 0.330 | 0.083 | DS, TBS |
| 12KL - 12.75 | 12.750 | 3.500 | 0.500 | 0.120 | DS, TBS |
| 12K - 12.75 | 12.750 | 3.500 | 0.625 | 0.120 | DS, TBS |
| 12KH - 12.75 | 12.750 | 4.000 | 0.750 | 0.188 | DS, TBS |
| 15K - 15.0 | 15.000 | 4.000 | 0.500 | 0.120 | DS, TBS |
| 16K - 16.0 | 16.000 | 4.500 | 0.625 | 0.120 | DS, TBS |
| 16KH - 16.0 | 16.000 | 5.500 | 0.750 | 0.188 | DS, TBS |
| 20X - 20.0 | 20.000 | 6.625 | 0.375 | 0.120 | DS, TBS |
| 20K - 20.0 | 20.000 | 6.625 | 0.500 | 0.120 | DS, TBS |
| 20KH - 20.0 | 20.000 | 6.625 | 0.750 | 0.188 | DS, TBS |
| 24KL - 24.0 | 24.000 | 8.625 | 0.500 | 0.188 | DS, TBS |
| 24K - 24.0 | 24.000 | 8.625 | 0.625 | 0.188 | DS, TBS |
| 24KH - 25.0 | 24.800 | 8.625 | 0.787 | 0.157 | DS, TBS |
| 26KH - 26.0 | 26.000 | 8.625 | 1.000 | 0.250 | DS, TBS |
| 27KH - 27.0 | 27.000 | 10.750 | 1.000 | 0.250 | DS, TBS |
| 36KH - 36.0 | 36.000 | 14.000 | 1.000 | 0.188 | DS, TBS |

CONTACT ABBHEY INTERNATIONAL LTD. FOR SPECIAL MILL SIZES AND APPLICATIONS

- Tube Walls Based on 50,000 PSI Maximum Material Yield
- Various Pass Arrangements and Options are Available for Each Mill Size
- Double Forming Mills are Designed like the Following Example: 2K - 4XL - 5.0
- Options: IS - Idle Squaring, DS - Driven Squaring, TBS - Transition Beam Forming
- Maximum Square Size can be Calculated by Dividing Max. Round Size by 1.25