

Tubetech, Inc.

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Capabilities Guide

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CAPABILITIES GUIDE

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O.D. and SHAPES

Round

.4375
.472
.5000 (1/2")
.511
.5250
.5625 (9/16")
.6250 (5/8")
.7500 (3/4")
.7650
.7870
.8580
.8750
.9100
1.0000
1.1250 (11/8")
1.2500 (11/4")
1.2600
1.3750
1.5000 (1 1/2")
1.6000
1.6250 (1 5/8")
1.6600
1.7500 (1 3/4")
2.0000
2.1250 (21/8")
2.1310
2.2500

Square

.7500 (3/4") Flat and Diamond
.8268 (21 mm) Flat
.945 Flat
* 1.0000 (1") Diamond
1.0000 (1") Flat
* Diamond weld in corner

Rectangle

.5000 x .5625 (1/2" x 9/16")
.6250 x .8750 (5/8" x 7/8")
17mm x 21mm

.7500 x 1.000 (3/4" x 1") Half Round

TUBEMILL CAPABILITIES

CURRENT DIAMETER x GAUGE COMBINATIONS AVAILABLE ROUND SIZES

<u>Outside Diameter</u>	<u>Gauge Range Uncoated Steel</u>	<u>Gauge Range Coated Steel</u>
.4375	.024 - .065	.034 - .065
.472	.024 - .049	.024-.049
.5000 (1/2")	.024 - .083	.024-.083
.511	.024 - .083	.024-.083
.5250	.024 -.070	.024-.070
.5625 (9/16")	.024 - .083	.024-.083
.6250 (5/8")	.024 -.110	.024-.110
.7500 (3/4")	.024 -.125	.024-.125
.7650 (sizing only)	.024 -.125	.024-.125
.7870	.024 - .049	.024-.049
.8580	.032 - .065	.032-.065
.8750 (7/8")	.021 - .090	.021 -.090
.9100	.024 - .120	.024-.120
1.0000 (1")	.021 -.126	.021 -.126
1.1250 (1 1/8")	.024 - .109	.024-.109
1.2500 (1 1/4")	.024 -.134	.024-.083
1.2600 (sizing only)	.024 -.134	.024-.083
1.3750	.024 -.065	.024 -.065
1.5000 (1 1/2")	.024 -.120	.024-.120
1.6000	.024 -.125	.024-.125
1.6250 (1 5/8")	.024 - .065	.024-.065
1.6600	.024 - .065	.024-.065
1.7500 (1 3/4")	.024 - .080	.024-.080
2.0000	.024 - .090	.024-.090
2.1250 (21/8")	.024 - .090	.024-.090
2.1310 (sizing only)	.024 - .090	.024-.090
2.2500 (21/4")	.035 - .090	.035-.090

TUBEMILL CAPABILITIES

CURRENT DIAMETER x GAUGE COMBINATIONS AVAILABLE SQUARE SIZES

<u>Outside Diameter</u>	<u>Gauge Range Uncoated Steel</u>	<u>Gauge Range Coated Steel</u>
.7500 (3/4")	.024 - .109	.024 - .109
.8268 (21 mm) Flat	.024 - .083	.024 - .083
.945 (21mm) Flat	.024 - .083	.024 - .083
1.0000 Diamond	.024 - .080	.024 - .080
1.0000 Flat	.024 - .100	.024 - .100

CURRENT DIAMETER x GAUGE COMBINATIONS AVAILABLE RECTANGLE SIZES

<u>Outside Diameter</u>	<u>Gauge Range Uncoated Steel</u>	<u>Gauge Range Coated Steel</u>
.5000 x .5625	.024 - .049	.024 - .049
.6250 x .8750	.024 - .065	.024 - .065
17 x 21mm	.024 - .108	.024 - .108
.7500x1.000 Half Round	.024-.065	.024 - .065

TUBEMILL CAPABILITIES

I.D. CUTTING CAPABILITIES PER TUBE SIZE INSIDE DIAMETER FLASH Round Sizes

.750 x 18 Smallest Size to I.D. Cut.

<u>Outside Diameter</u>	<u>Gauge Range</u>	<u>Cut</u>
.7500 (3/4")	.024 - .049	+0.003 / -.002
.7650	.024 - .049	+0.003 / -.002
.7870	.024 - .049	+0.003 / -.002
.8580	.032 - .065	+0.003 / -.002
.8750 (7/8")	.021 - .090	+0.003 / -.002
.9100	.024 - .049	+0.003 / -.002
1.0000 (1")	.021 - .126	+0.003 / -.002
1.1250 (1 1/8")	.024 - .109	+0.003 / -.002
1.2500 (1 1/4")	.024 - .134	+0.003 / -.002
1.2600	.024 - .095	+0.003 / -.002
1.3750	.024 - .095	+0.003 / -.002
1.5000 (1 1/2")	.024 - .120	+0.003 / -.002
1.6000	.024 - .125	+0.003 / -.002
1.6250 (1 5/8")	.024 - .065	+0.003 / -.002
1.6600	.024 - .065	+0.003 / -.002
1.7500 (1 3/4")	.024 - .083	+0.003 / -.002
2.0000	.024 - .090	+0.003 / -.002
2.1250 (2 1/8")	.024 - .090	+0.003 / -.002
2.2500 (2 1/4")	.035 - .090	+0.003 / -.002

TUBEMILL CAPABILITIES

I.D. CUTTING CAPABILITIES PER TUBE SIZE INSIDE DIAMETER FLASH Square Sizes

<u>Outside Diameter</u>	<u>Gauge Range</u>	<u>Cut</u>
.7500sq (3/4"sq)	.024 - .065	+ .003 /- .002
.8268	.028 - .083	
.875	.028 - .083	
1.000	.028-.1.00	

* 3/4" x 18 smallest O.D. to Flash Cut *

* 1 1/2" O.D. and larger Flash Cut Galvanized Product *

<u>Flash Control</u>	
	22ga .010 max
	20ga .010 max
	18ga .015 max
	16ga .020 max
	14ga .025 max

Note + .031" is the best length tolerance Tubetech can hold on all tubemills.

RE-CUTTING CAPABILITIES

HAVEN Horizontal and Vertical Shear Cut

Length Tolerance	+/- .010
Minimum Cut Length	5" (need special jaws for shorter tube)
O.D. Range	1/2" to 3"
Brush Deburr Minimum	5.7" to 79" Haven I 6.5" to 79" Haven II

CURRENT O.D. and SHAPE TOOLING

<u>Round</u>	<u>Gauge</u>	
.4375	.024 - .065	1 Set
.472	.024 - .065	2 Sets
.5000 (1/2")	.024-.120	2 Sets
.5070	.024-.120	
.511	.024-.120	
.5260	.024-.120	2 Sets
.5625 (9/16")	.024 - .120	
.6250 (5/8")	.024-.120	4 Sets
.6300	.024-.120	
.7480	.024-.120	2 Sets
.7500 (3/4")	.024-.120	3 Sets
.7520	.024-.120	
.7540	.024-.120	
.7650	.024-.120	2 Sets
.7870	.024-.120	
.8750 (7/8")	.024-.120	2 Sets
1.0000 (1"),	.024-.120	3 Sets (1 Set Light Wall)
1.1250 (1 1/8")	.024-.120	2 Sets
1.2500 (1 1/4")	.024-.120	4 Sets (2 Set Light Wall)
1.3780	.024 -.120	2 Sets
1.5000 (1 1/2")	.024 -.120	2 Sets
1.5100	.024 -.120	2 Sets
1.6250 (1 5/8")	.024 -.120	
1.6650	.024 -.120	
1.7500	.024 -.120	2 Sets
1,7700	.024 -.120	
2.0000	.024 -.120	2 Sets
2.1250	.024 -.120	
2.1310	.024 -.120	
2.2500	.024 -.120	2 Sets

RE-CUTTING CAPABILITIES

HAVEN Horizontal and Vertical Shear Cut CURRENT O.D. and SHAPE TOOLING

(continued)

Shapes

Gauge

5/8 x 7/8	.062 Radius	
5/8 x 7/8	.098 Radius	
.7500"sq	.024-.120	2 Sets (1 Set Harper Wyman Corner)
.8268 sq	.024-.120	4 Sets
.8750 sq	.024-.120	2 Sets
1.000"sq	.024-.120	
1.940x1.430 oval	.024-.120	

Short Jaws

.7500
1.0000
2.2500

RE-CUTTING CAPABILITIES

ROLLER DEDIMPLER, END FACE AND BRUSH MACHINE

O.D. CAPABILITIES

.5000	(1/2")
.6250	(5/8")
.7500	(3/4")
.8580	
.9100	
1.0000	(1")
1.1250	(1 1/8")
1.2500	(1 1/4")
1.5000	(1 1/2")
1.7500	(1 3/4")
2.0000	(2")
2.1250	(2 1/8")

Minimum length <u>with</u> center support	17 inches
Maximum length <u>with</u> center support	14 feet
Minimum length <u>without</u> center support	10.5 inches