

403-3-4, K-3-4, 310-3-48 Capacity Chart



Base Capacity	0.06	Top roll diameter	3	Working Length	48	Solving for Material Width in Inches										
						One Pass Rolling!										
Plate Thickness →		20ga	18ga	16ga	14ga	12ga	10ga	8ga	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"		
Yield Strength PSI ↓	ID (in) ↓	0.0359	0.0478	0.0598	0.0747	0.1046	0.1345	0.1644	0.1875	0.25	0.3125	0.375	0.4375	0.5		
30,000	3.3	48.00	36.30	23.19	7.43	3.79	2.29	1.53	1.18	0.66	0.42					
	3.6	48.00	42.60	27.22	17.44	4.45	2.69	1.80	1.38	0.78	0.50					
	3.75	48.00	48.00	31.57	20.23	5.16	3.12	2.09	1.61	0.90	0.58	0.40				
	4.5	48.00	48.00	41.23	26.43	6.74	4.08	2.73	2.10	1.18	0.75	0.52				
	5.25	48.00	48.00	41.23	26.43	6.74	4.08	2.73	2.10	1.18	0.75	0.52				
	6	48.00	48.00	48.00	33.44	17.06	5.16	3.45	2.65	1.49	0.96	0.66	0.49			
	7.5	48.00	48.00	48.00	35.71	18.21	5.51	3.69	2.83	1.59	1.02	0.71	0.52			
	9	48.00	48.00	48.00	37.26	19.00	5.75	3.85	2.96	1.66	1.06	0.74	0.54			
	10.5	48.00	48.00	48.00	39.65	20.22	6.12	4.09	3.15	1.77	1.13	0.79	0.58			
	12	48.00	48.00	48.00	41.29	21.06	6.37	4.26	3.28	1.84	1.18	0.82	0.60			
	15	48.00	48.00	48.00	46.39	23.66	7.16	4.79	3.68	2.07	1.33	0.92	0.68	0.52		
	18	48.00	48.00	48.00	48.00	24.56	7.43	4.97	3.82	2.15	1.38	0.96	0.70	0.54		
40,000	24	48.00	48.00	48.00	48.00	25.95	7.85	5.25	4.04	2.27	1.45	1.01	0.74	0.57		
	30	48.00	48.00	48.00	48.00	27.85	16.84	5.64	4.33	2.44	1.56	1.08	0.80	0.61		
	3.3	48.00	27.23	17.40	5.57	2.84	1.72	1.15	0.88	0.50	0.32					
	3.6	48.00	31.95	20.42	6.54	3.34	2.02	1.35	1.04	0.58	0.37					
	3.75	48.00	37.06	23.68	7.59	3.87	2.34	1.57	1.20	0.68	0.43					
	4.5	48.00	48.00	30.93	19.82	5.05	3.06	2.05	1.57	0.88	0.57	0.39				
	5.25	48.00	48.00	30.93	19.82	5.05	3.06	2.05	1.57	0.88	0.57	0.39				
	6	48.00	48.00	39.14	25.08	6.40	3.87	2.59	1.99	1.12	0.72	0.50				
	7.5	48.00	48.00	41.79	26.78	6.83	4.13	2.76	2.13	1.20	0.77	0.53				
	9	48.00	48.00	43.61	27.95	7.13	4.31	2.89	2.22	1.25	0.80	0.55				
	10.5	48.00	48.00	46.41	29.74	7.58	4.59	3.07	2.36	1.33	0.85	0.59				
	12	48.00	48.00	48.00	30.97	7.90	4.78	3.20	2.46	1.38	0.88	0.61	0.45			
50,000	15	48.00	48.00	48.00	34.79	17.75	5.37	3.59	2.76	1.55	0.99	0.69	0.51			
	18	48.00	48.00	48.00	36.12	18.42	5.57	3.73	2.87	1.61	1.03	0.72	0.53			
	24	48.00	48.00	48.00	38.15	19.46	5.88	3.94	3.03	1.70	1.09	0.76	0.56			
	30	48.00	48.00	48.00	40.95	20.89	6.32	4.23	3.25	1.83	1.17	0.81	0.60			
	3.3	38.61	21.78	6.96	4.46	2.27	1.38	0.92	0.71	0.40						
	3.6	45.32	25.56	16.33	5.23	2.67	1.61	1.08	0.83	0.47						
	3.75	48.00	29.65	18.94	6.07	3.10	1.87	1.25	0.96	0.54	0.35					
	4.5	48.00	38.72	24.74	7.93	4.04	2.45	1.64	1.26	0.71	0.45					
	5.25	48.00	38.72	24.74	7.93	4.04	2.45	1.64	1.26	0.71	0.45					
	6	48.00	48.00	31.31	20.07	5.12	3.09	2.07	1.59	0.90	0.57	0.40				
	7.5	48.00	48.00	33.43	21.43	5.46	3.30	2.21	1.70	0.96	0.61	0.43				
	9	48.00	48.00	34.89	22.36	5.70	3.45	2.31	1.77	1.00	0.64	0.44				
60,000	10.5	48.00	48.00	37.13	23.79	6.07	3.67	2.46	1.89	1.06	0.68	0.47				
	12	48.00	48.00	38.66	24.77	6.32	3.82	2.56	1.97	1.11	0.71	0.49				
	15	48.00	48.00	43.44	27.84	7.10	4.29	2.87	2.21	1.24	0.80	0.55				
	18	48.00	48.00	45.09	28.90	7.37	4.46	2.98	2.29	1.29	0.83	0.57				
	24	48.00	48.00	47.63	30.52	7.78	4.71	3.15	2.42	1.36	0.87	0.61	0.44			
	30	48.00	48.00	48.00	32.76	16.71	5.05	3.38	2.60	1.46	0.94	0.65	0.48			
	3.3	32.18	18.15	5.80	3.72	1.90	1.15	0.77	0.59	0.33						
	3.6	37.77	21.30	6.81	4.36	2.22	1.35	0.90	0.69	0.39						
	3.75	43.80	24.71	7.89	5.06	2.58	1.56	1.04	0.80	0.45						
	4.5	48.00	32.27	20.62	6.61	3.37	2.04	1.36	1.05	0.59	0.38					
	5.25	48.00	32.27	20.62	6.61	3.37	2.04	1.36	1.05	0.59	0.38					
	6	48.00	40.84	26.09	16.72	4.26	2.58	1.73	1.33	0.75	0.48					
100,000	7.5	48.00	43.61	27.86	17.86	4.55	2.75	1.84	1.42	0.80	0.51					
	9	48.00	45.50	29.07	18.63	4.75	2.87	1.92	1.48	0.83	0.53					
	10.5	48.00	48.00	30.94	19.83	5.06	3.06	2.05	1.57	0.89	0.57	0.39				
	12	48.00	48.00	32.21	20.64	5.26	3.18	2.13	1.64	0.92	0.59	0.41				
	15	48.00	48.00	36.20	23.20	5.92	3.58	2.39	1.84	1.04	0.66	0.46				
	18	48.00	48.00	37.57	24.08	6.14	3.71	2.49	1.91	1.07	0.69	0.48				
	24	48.00	48.00	39.69	25.44	6.49	3.92	2.63	2.02	1.14	0.73	0.50				
	30	48.00	48.00	42.60	27.30	6.96	4.21	2.82	2.17	1.22	0.78	0.54				
	3.3	19.31	5.45	3.48	2.23	1.14	0.69	0.46	0.35							
	3.6	22.66	6.39	4.08	2.62	1.33	0.81	0.54	0.42							
	3.75	26.28	7.41	4.74	3.03	1.55	0.94	0.63	0.48	0.27						
	Info found here is to be used as a guideline, Please contact sales@wdmrolls.com for questions. These capacities are based on the tonnage capacity of the machine. Because of the spring back of some of the materials, the minimum diameter may not be attainable. See the following chart for approximate minimum diameter. →	4.5	34.32	19.36	6.19	3.96	2.02	1.22	0.82	0.63	0.35					
5.25		34.32	19.36	6.19	3.96	2.02	1.22	0.82	0.63	0.35						
6		43.44	24.50	7.83	5.02	2.56	1.55	1.04	0.80	0.45						
7.5		46.39	26.16	16.72	5.36	2.73	1.65	1.11	0.85	0.48						
9		48.00	27.30	17.44	5.59	2.85	1.72	1.15	0.89	0.50	0.32					
10.5		48.00	29.05	18.56	5.95	3.03	1.83	1.23	0.94	0.53	0.34					
12		48.00	30.25	19.33	6.19	3.16	1.91	1.28	0.98	0.55	0.35					
15		48.00	33.99	21.72	6.96	3.55	2.15	1.44	1.10	0.62	0.40					
18		48.00	35.29	22.54	7.22	3.68	2.23	1.49	1.15	0.64	0.41					
24		48.00	37.27	23.81	7.63	3.89	2.35	1.58	1.21	0.68	0.44					
30		48.00	40.01	25.56	16.38	4.18	2.53	1.69	1.30	0.73	0.47					
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					Mild Steel, i.e. M-1020, A-36 - ID					3.75						
					CR Sheet, Thin Galvanized, Half Hard Copper, SS -ID					4.50						
					AR Plate, T-1, Other Super Alloys - ID					6.00						