



# 430-6-8 Prebend Capacity Chart

Base Capacity		0.125	Top roll diameter			6	Working Length			96	Solving for Material Width in Inches One Pass Rolling!				
Plate Thickness →	Yield Strength PSI ↓	ID (in) ↓	20ga 0.0359	18ga 0.0478	16ga 0.0598	14ga 0.0747	12ga 0.1046	10ga 0.1345	8ga 0.1644	3/16" 0.1875	1/4" 0.25	5/16" 0.3125			
30,000	6.6	96.00	96.00	96.00	96.00	96.00	65.81	39.80	13.32						
	7.2	96.00	96.00	96.00	96.00	96.00	77.23	46.71	15.63	12.02					
	7.5	96.00	96.00	96.00	96.00	96.00	89.57	54.17	36.26	13.94					
	9	96.00	96.00	96.00	96.00	96.00	96.00	70.76	47.36	36.41					
	10.5	96.00	96.00	96.00	96.00	96.00	96.00	70.76	47.36	36.41					
	12	96.00	96.00	96.00	96.00	96.00	96.00	89.55	59.94	46.08	12.96				
	15	96.00	96.00	96.00	96.00	96.00	96.00	95.62	64.00	49.20	13.84				
	18	96.00	96.00	96.00	96.00	96.00	96.00	96.00	66.78	51.34	14.44				
	21	96.00	96.00	96.00	96.00	96.00	96.00	96.00	71.07	54.64	15.37				
	24	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	74.00	56.89	32.00			
	30	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	83.15	63.92	35.96			
	36	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	86.31	66.36	37.32			
48	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	91.17	70.09	39.43	12.62			
60	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	75.24	42.32	13.54			
40,000	6.6	96.00	96.00	96.00	96.00	96.00	49.35	14.93							
	7.2	96.00	96.00	96.00	96.00	96.00	57.92	35.03							
	7.5	96.00	96.00	96.00	96.00	96.00	67.18	40.63	13.60						
	9	96.00	96.00	96.00	96.00	96.00	87.74	53.07	35.52	13.65					
	10.5	96.00	96.00	96.00	96.00	96.00	87.74	53.07	35.52	13.65					
	12	96.00	96.00	96.00	96.00	96.00	96.00	67.16	44.95	34.56					
	15	96.00	96.00	96.00	96.00	96.00	96.00	71.72	48.00	36.90					
	18	96.00	96.00	96.00	96.00	96.00	96.00	74.83	50.09	38.51					
	21	96.00	96.00	96.00	96.00	96.00	96.00	79.63	53.30	40.98					
	24	96.00	96.00	96.00	96.00	96.00	96.00	82.92	55.50	42.67	12.00				
	30	96.00	96.00	96.00	96.00	96.00	96.00	93.17	62.36	47.94	13.48				
	36	96.00	96.00	96.00	96.00	96.00	96.00	96.00	64.73	49.77	14.00				
48	96.00	96.00	96.00	96.00	96.00	96.00	96.00	68.38	52.57	14.79					
60	96.00	96.00	96.00	96.00	96.00	96.00	96.00	73.40	56.43	15.87					
50,000	6.6	96.00	96.00	96.00	96.00	77.42	39.48								
	7.2	96.00	96.00	96.00	96.00	90.86	46.34	14.01							
	7.5	96.00	96.00	96.00	96.00	96.00	53.74	32.50							
	9	96.00	96.00	96.00	96.00	96.00	70.19	42.45	14.21						
	10.5	96.00	96.00	96.00	96.00	96.00	70.19	42.45	14.21						
	12	96.00	96.00	96.00	96.00	96.00	88.84	53.73	35.96	13.82					
	15	96.00	96.00	96.00	96.00	96.00	94.86	57.37	38.40	14.76					
	18	96.00	96.00	96.00	96.00	96.00	96.00	59.87	40.07	15.40					
	21	96.00	96.00	96.00	96.00	96.00	96.00	63.71	42.64	32.78					
	24	96.00	96.00	96.00	96.00	96.00	96.00	66.33	44.40	34.13					
	30	96.00	96.00	96.00	96.00	96.00	96.00	74.53	49.89	38.35					
	36	96.00	96.00	96.00	96.00	96.00	96.00	77.37	51.79	39.81					
48	96.00	96.00	96.00	96.00	96.00	96.00	81.73	54.70	42.06						
60	96.00	96.00	96.00	96.00	96.00	96.00	87.73	58.72	45.14	12.70					
60,000	6.6	96.00	96.00	96.00	96.00	64.52	32.90								
	7.2	96.00	96.00	96.00	96.00	75.72	38.62								
	7.5	96.00	96.00	96.00	96.00	87.81	44.79	13.54							
	9	96.00	96.00	96.00	96.00	96.00	58.49	35.38							
	10.5	96.00	96.00	96.00	96.00	96.00	58.49	35.38							
	12	96.00	96.00	96.00	96.00	96.00	74.03	44.78	14.98						
	15	96.00	96.00	96.00	96.00	96.00	79.05	47.81	32.00	12.30					
	18	96.00	96.00	96.00	96.00	96.00	82.49	49.89	33.39	12.84					
	21	96.00	96.00	96.00	96.00	96.00	87.78	53.09	35.53	13.66					
	24	96.00	96.00	96.00	96.00	96.00	91.40	55.28	37.00	14.22					
	30	96.00	96.00	96.00	96.00	96.00	96.00	62.11	41.57	15.98					
	36	96.00	96.00	96.00	96.00	96.00	96.00	64.48	43.16	33.18					
48	96.00	96.00	96.00	96.00	96.00	96.00	68.11	45.59	35.05						
60	96.00	96.00	96.00	96.00	96.00	96.00	73.11	48.93	37.62						
100,000	6.6	96.00	94.54	60.40	38.71										
	7.2	96.00	96.00	70.89	45.43										
	7.5	96.00	96.00	82.21	52.69	13.44									
	9	96.00	96.00	96.00	68.82	35.10									
	10.5	96.00	96.00	96.00	68.82	35.10									
	12	96.00	96.00	96.00	87.10	44.42	13.43								
	15	96.00	96.00	96.00	93.00	47.43	14.34								
	18	96.00	96.00	96.00	96.00	49.49	14.97								
	21	96.00	96.00	96.00	96.00	52.67	15.93								
	24	96.00	96.00	96.00	96.00	54.84	33.17								
	30	96.00	96.00	96.00	96.00	61.62	37.27	12.47							
	36	96.00	96.00	96.00	96.00	63.96	38.69	12.95							
48	96.00	96.00	96.00	96.00	67.57	40.87	13.68								
60	96.00	96.00	96.00	96.00	72.52	43.86	14.68								

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. →

Wrought Iron/1010 MS, Soft Aluminium and Copper - ID	6.60
Mild Steel, i.e. M-1020, A-36 - ID	7.50
CR Sheet, Thin Galvanized, Half Hard Copper, SS - ID	9.00
AR Plate, T-1, Other Super Alloys - ID	12.00