



# 430-8-8 Prebend Capacity Chart

Base Capacity		0.25		Top roll diameter		8		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	3/8" 0.375	7/16" 0.4375		
30,000	8.8	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	81.92	46.08	14.75			
	9.6	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	34.61	12.02		
	10	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	62.72	40.14	13.94		
	12	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	81.92	52.43	36.41	13.37	
	14	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	81.92	52.43	36.41	13.37	
	16	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	66.36	46.08	33.85	
	20	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	70.85	49.20	36.15	
	24	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	73.93	51.34	37.72	
	28	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	78.68	54.64	40.14	
	32	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	81.92	56.89	41.80	
	40	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	92.05	63.92	46.96	
	48	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	95.55	66.36	48.75	
64	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	70.09	51.50		
80	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	75.24	55.28		
40,000	8.8	96.00	96.00	96.00	96.00	96.00	96.00	96.00	79.92	61.44	34.56					
	9.6	96.00	96.00	96.00	96.00	96.00	96.00	96.00	93.79	72.11	40.56	12.98				
	10	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	83.63	47.04	15.05				
	12	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	61.44	39.32	13.65			
	14	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	61.44	39.32	13.65			
	16	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	77.76	49.77	34.56	12.70		
	20	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	83.03	53.14	36.90	13.56		
	24	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	86.64	55.45	38.51	14.15	
	28	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	92.20	59.01	40.98	15.05	
	32	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	61.44	42.67	15.67	
	40	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	69.03	47.94	35.22	
	48	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	71.66	49.77	36.56	
64	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	75.70	52.57	38.62		
80	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	81.25	56.43	41.46		
50,000	8.8	96.00	96.00	96.00	96.00	96.00	96.00	95.52	63.94	49.15	13.82					
	9.6	96.00	96.00	96.00	96.00	96.00	96.00	96.00	75.04	57.69	32.45					
	10	96.00	96.00	96.00	96.00	96.00	96.00	96.00	87.02	66.90	37.63	12.04				
	12	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	87.38	49.15	15.73				
	14	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	87.38	49.15	15.73				
	16	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	62.21	39.81	13.82			
	20	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	66.42	42.51	14.76			
	24	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	69.31	44.36	15.40			
	28	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	73.76	47.21	32.78	12.04		
	32	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	76.80	49.15	34.13	12.54		
	40	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	86.29	55.23	38.35	14.09		
	48	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	89.58	57.33	39.81	14.63		
64	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	94.63	60.56	42.06	15.45			
80	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	65.00	45.14	33.17		
60,000	8.8	96.00	96.00	96.00	96.00	96.00	96.00	79.60	53.28	40.96						
	9.6	96.00	96.00	96.00	96.00	96.00	96.00	93.42	62.53	48.07	13.52					
	10	96.00	96.00	96.00	96.00	96.00	96.00	96.00	72.52	55.75	15.68					
	12	96.00	96.00	96.00	96.00	96.00	96.00	96.00	94.72	72.82	40.96	13.11				
	14	96.00	96.00	96.00	96.00	96.00	96.00	96.00	94.72	72.82	40.96	13.11				
	16	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	92.16	51.84	33.18				
	20	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	55.35	35.43	12.30			
	24	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	57.76	36.97	12.84			
	28	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	61.47	39.34	13.66			
	32	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	64.00	40.96	14.22			
	40	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	71.91	46.02	15.98			
	48	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	74.65	47.78	33.18	12.19		
64	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	78.85	50.47	35.05	12.87			
80	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	84.64	54.17	37.62	13.82			
100,000	8.8	96.00	96.00	96.00	96.00	96.00	78.97	47.76	15.98	12.29						
	9.6	96.00	96.00	96.00	96.00	96.00	92.68	56.05	37.52	14.42						
	10	96.00	96.00	96.00	96.00	96.00	96.00	65.01	43.51	33.45						
	12	96.00	96.00	96.00	96.00	96.00	96.00	84.91	56.83	43.69	12.29					
	14	96.00	96.00	96.00	96.00	96.00	96.00	84.91	56.83	43.69	12.29					
	16	96.00	96.00	96.00	96.00	96.00	96.00	96.00	71.93	55.30	15.55					
	20	96.00	96.00	96.00	96.00	96.00	96.00	96.00	76.80	59.04	33.21					
	24	96.00	96.00	96.00	96.00	96.00	96.00	96.00	80.14	61.61	34.66					
	28	96.00	96.00	96.00	96.00	96.00	96.00	96.00	85.28	65.56	36.88					
	32	96.00	96.00	96.00	96.00	96.00	96.00	96.00	88.80	68.27	38.40	12.29				
	40	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	76.70	43.15	13.81				
	48	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	79.63	44.79	14.33				
64	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	84.11	47.31	15.14					
80	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	90.28	50.78	32.50					

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	8.80
Mild Steel, i.e. M-1020, A-36 - ID	10.00
CR Sheet, Thin Galvanized, Half Hard Copper, SS - ID	12.00
AR Plate, T-1, Other Super Alloys - ID	16.00