






















SECTION ROLLING CHART

Type	Position	Section	Capacity	With Standard Rolls	Notes	Capacity	With Special Rolls	Notes	Total Grip Allowance. Required at capacity.
1	Flange out Leg out		Max. 6" x 6" x 1"	To Ø100"	a				48"
2	Flange in Leg in		Max. 6" x 6" x 1"	To Ø130"	a				48"
3	Stem out		Max. WT6	To Ø90"	a				26"
4	Stem in		Max. WT6	To Ø110"	a				26"
5	Stem up		Max. WT6	To Ø85"	a				26"
6	Hard way		Max. 8" x 1-1/2" Max. 6" x 2-1/2"	To Ø100" To Ø70"	a				32"
7	Easy way		Max. 12" x 2"	To Ø45"	a				24"
8	Hard way		Max. 4-1/2" x 2-1/2"	To Ø60"	a				24"
9						Max. Ø5"	To Ø50"		24"
10						Max. O.D. 8-5/8"	To Ø120"		50"
11						Max. 6" x 6" x 3/8" Max. 7" x 7" x 3/8"	To Ø480" To Ø840"	b	34"
12						Max. S20 x 70	To Ø180"		30"
13						Max. W12 x 50 Max. W10 x 49	To Ø120" To Ø180"		30"
14	Flange out Leg out					Max. C15 x 50 Min. C4	To Ø60" To Ø30"		30"
15	Flange in Leg in					Max. C15 x 50 Min. C4	To Ø70" To Ø30"		30"
16	Hard way		C10 and larger does not produce acceptable results			Max. C8 x 18.75 Min. C4	To Ø410" To Ø70"		48"
17	Hard way					Max. S10 x 25.4	To Ø1800"		40"
18	Hard way					Max. W10 x 22 Max. 8 x 21 Max. W6 x 5	To Ø1800" To Ø200" To Ø150"		40"
19	Camber					W30 x 148			
20	Peak out					Max. 2-1/2" x 2-1/2" x 3/8"	To Ø36"		15"
21	Peak in					Max. 2-1/2" x 2-1/2" x 3/8"	To Ø36"		15"

Quality of material: A36

All data are valid for mild steel with yield point 270 N/mm²

Max. section modules: 11-20 inch³ depending on bending diameter

Note a: Indicated diameters are valid for max. section in one of few passes. Smaller sections can be bent into smaller diameters.

Note b: Smallest bending diameter depends on grade or deformation that can be accepted.