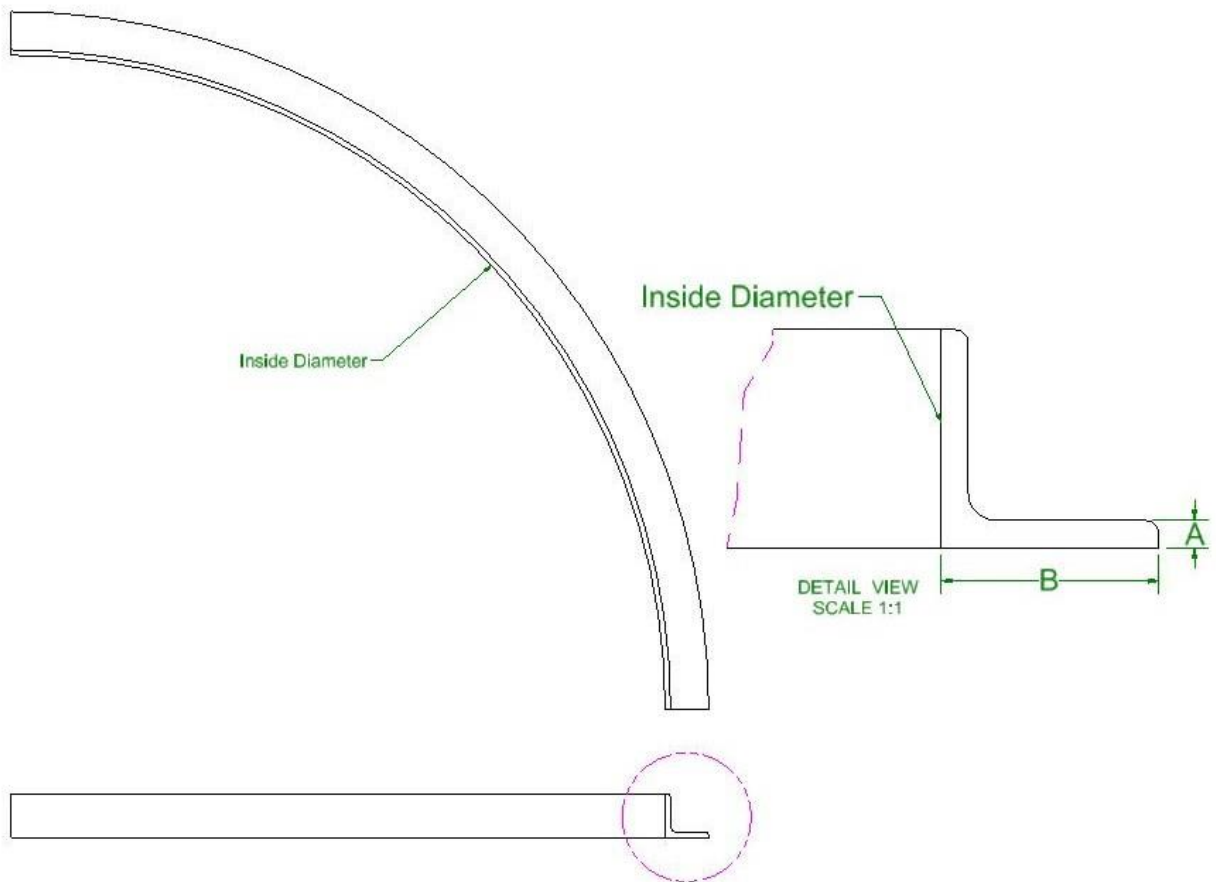


Rule of "10"

General guideline for **rolling** viability of structurals

Although there are exceptions to this guide, the rule of "10" is a quick reference to assist in determining whether angles or structurals can be rolled.



Where A is greater than $1/10^{\text{th}}$ B , and where the inside diameter of the rolled structural is greater than $10X$ B , rolling is generally possible.

This ratio can also be applied generally to other structurals:

2" pipe can be rolled to 10x the nominal size etc.

This ratio does not apply to channels and beams rolled the hard way where much greater factors need to be allowed.

In some cases, we have been able to roll tighter than this rule would suggest. Likewise, different forms of bending, rather than rolling can achieve tighter diameters.

Call us with your specific forming request and we can be more precise.