









Section Rolling Chart Standard Rolls

Type	Position	Section	Capacity	With Standard Rolls	Notes	Total Grip Allowance Required at Capacity
1	Flange Out Leg Out		Max. 6" x 6" x 1"	to Ø100"	a	44"
2	Flange In Leg In		Max. 6" x 6" x 1"	to Ø130"	a	52"
3	Stem Out		Max. WT6	to Ø90"	a	30"
4	Stem In		Max. WT6	to Ø110"	a	30"
5	Stem Up		Max. WT6	to Ø85"	a	30"
6	Hard Way		Max. 8" x 1.5" Max 6" x 2.5"	to Ø100" to Ø70"	a	36"
7	Easy Way		Max. 12" x 2"	to Ø45"	a	24"
8	Hard Way		Max. 4.5" x 2.5"	to Ø60"	a	24"

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.

Section Rolling Chart: Special Rolls

Type	Position	Section	Capacity	With Special Rolls	Notes	Total Grip Allowance Required at Capacity
9			Max. Ø5"	to Ø50"		24"
10			Max O.D. 8.625"	to Ø120"		40"
11			Max. 6" x 6" x 3/8" Max 7" x 7" x 3/8"	to Ø480" to Ø840"	b	36"
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		W33 x 141			See AISC Beam Cambering Tolerances sheet
20	Peak Out		Max. 2-1/2" x 2-1/2" x 3/8"	to Ø36"		15"
20	Peak In		Max. 2-1/2" x 2-1/2" x 3/8"	to Ø36"		15"