

MATERIAL WIDTH CAPACITY CHART

WDM MODEL	403-6-6	CAPACITY FOR BENDING AND PREBENDING AT 1 PASS ROLLING .220 BASE CAPACITY										
Plate Thickness	Fraction	13 ga	12 ga	11 ga	10 ga	9 ga	8 ga	7g/3/16	1/4	5/16	3/8	7/16
	Decimal	.0897	.1046	.1196	.1345	.1495	.1644	.1793	.250	.312	.375	.437

Mat. yields	ID											
30,000 PSI	6.6					72	61	52	26			
	7.8						72	70	36			
	9							72	47	30		
	12							72	60	38	26	
	18							72	67	43	29	
	24								72	47	33	24
	30								72	53	37	27
40,000 PSI	6.6			72	69	56	46	39				
	7.8				72	76	63	53	27			
	9						72	69	35			
	12							72	45	28		
	18							72	50	32		
	24							72	55	35		
	30							72	62	40		
50,000 PSI	6.6		72	70	55	44	37	31				
	7.8				72	61	50	42				
	9					72	66	55	28			
	12						72	70	36			
	18							72	40	25		
	24							72	44	28		
	30							72	50	32		
65,000 PSI	6.6	72	70	53	42	34	28	24				
	7.8			72	58	47	38	32				
	9				72	61	50	42				
	12					72	64	54				
	18						71	60	30			
	24							74	34			
	30								38	24		
100,000 PSI	6.6	62	45	35	27							
	7.8	72	62	47	37	30	25					
	9		72	62	49	39	33	27				
	12			72	62	50	41	35	18			
	18			72	69	56	46	39				
	24				72	62	51	43				
	30					72	70	57	48			
60						72	68	57				

These capacities are based on the tonnage capacity of the machine. Because of the spring back of some materials, the minimum diameter may not be attainable.

29 See the following chart for approximate minimum diameter of different material.

Top Roll Diameter	
Wrought Iron/1010 Mild Steel	1.1 x Top Roll Diameter
Mild Steel, i.e. M-1020	1.2 x Top Roll Diameter
Cold Rolled Sheet or Thin Galvanized Sheet, i.e. 20-28 ga	1.5 x Top Roll Diameter
Soft Aluminum	1.1 x Top Roll Diameter
Tempered Aluminum, i.e. 6061T6	2 x Top Roll Diameter
Soft Copper	1.1 x Top Roll Diameter
Half Hard Copper	1.5 x Top Roll Diameter
Stainless Steel, Monel, Etc.	1.2 to 1.4 x Top Roll
A.R. Plate, T-1, Other Super	2 or more x Top Roll Di.