

403-8-6, K-8-6 Capacity Chart

| Base Capacity | | 0.37 | Top roll diameter | | 8 | Working Length | | 72 | Solving for Material Width in Inches | | | | | |
|--|-----------|--------|-------------------|--------|-------|----------------|--|--------|--------------------------------------|--------|-------|-------|-------|------|
| | | | One Pass Rolling! | | | | | | | | | | | |
| Plate Thickness → | ID (in) ↓ | 10ga | 8ga | 3/16" | 1/4" | 5/16" | 3/8" | 7/16" | 1/2" | 9/16" | 5/8" | 3/4" | 7/8" | |
| Yield Strength PSI ↓ | ID (in) ↓ | 0.1345 | 0.1644 | 0.1875 | 0.25 | 0.3125 | 0.375 | 0.4375 | 0.5 | 0.5625 | 0.625 | 0.75 | 0.875 | |
| 30,000 | 8.8 | 72.00 | 72.00 | 72.00 | 72.00 | 48.45 | 33.64 | 24.72 | 9.46 | 7.48 | 6.06 | 4.21 | 3.09 | |
| | 9.6 | 72.00 | 72.00 | 72.00 | 72.00 | 56.86 | 39.49 | 29.01 | 11.11 | 8.77 | 7.11 | 4.94 | 3.63 | |
| | 10 | 72.00 | 72.00 | 72.00 | 72.00 | 65.94 | 45.79 | 33.64 | 25.76 | 10.18 | 8.24 | 5.72 | 4.21 | |
| | 12 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 59.81 | 43.94 | 33.64 | 26.58 | 10.77 | 7.48 | 5.49 | |
| | 14 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 59.81 | 43.94 | 33.64 | 26.58 | 10.77 | 7.48 | 5.49 | |
| | 16 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 55.62 | 42.58 | 33.64 | 27.25 | 9.46 | 6.95 | |
| | 20 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 59.39 | 45.47 | 35.92 | 29.10 | 10.10 | 7.42 | |
| | 24 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 61.97 | 47.44 | 37.49 | 30.36 | 10.54 | 7.75 | |
| | 28 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 65.94 | 50.49 | 39.89 | 32.31 | 11.22 | 8.24 | |
| | 32 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 68.66 | 52.57 | 41.54 | 33.64 | 11.68 | 8.58 |
| | 40 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 59.07 | 46.67 | 37.80 | 26.25 | 9.64 |
| 48 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 61.32 | 48.45 | 39.24 | 27.25 | 10.01 | |
| 64 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 64.77 | 51.18 | 41.45 | 28.79 | 10.57 | |
| 80 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 69.52 | 54.93 | 44.49 | 30.90 | 11.35 | |
| 40,000 | 8.8 | 72.00 | 72.00 | 72.00 | 56.78 | 36.34 | 25.23 | 9.27 | 7.10 | 5.61 | 4.54 | 3.15 | 2.32 | |
| | 9.6 | 72.00 | 72.00 | 72.00 | 66.63 | 42.64 | 29.61 | 10.88 | 8.33 | 6.58 | 5.33 | 3.70 | 2.72 | |
| | 10 | 72.00 | 72.00 | 72.00 | 72.00 | 49.46 | 34.35 | 25.23 | 9.66 | 7.63 | 6.18 | 4.29 | 3.15 | |
| | 12 | 72.00 | 72.00 | 72.00 | 72.00 | 64.60 | 44.86 | 32.96 | 25.23 | 9.97 | 8.07 | 5.61 | 4.12 | |
| | 14 | 72.00 | 72.00 | 72.00 | 72.00 | 64.60 | 44.86 | 32.96 | 25.23 | 9.97 | 8.07 | 5.61 | 4.12 | |
| | 16 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 56.78 | 41.71 | 31.94 | 25.23 | 10.22 | 7.10 | 5.21 | |
| | 20 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 60.62 | 44.54 | 34.10 | 26.94 | 10.91 | 7.58 | 5.57 | |
| | 24 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 63.26 | 46.48 | 35.58 | 28.12 | 11.39 | 7.91 | 5.81 | |
| | 28 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 67.32 | 49.46 | 37.87 | 29.92 | 24.23 | 8.41 | 6.18 | |
| | 32 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 70.09 | 51.50 | 39.43 | 31.15 | 25.23 | 8.76 | 6.44 | |
| | 40 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 57.86 | 44.30 | 35.00 | 28.35 | 9.84 | 7.23 | |
| 48 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 60.07 | 45.99 | 36.34 | 29.43 | 10.22 | 7.51 | | |
| 64 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 63.45 | 48.58 | 38.38 | 31.09 | 10.80 | 7.93 | | |
| 80 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 68.10 | 52.14 | 41.20 | 33.37 | 11.59 | 8.51 | | |
| 50,000 | 8.8 | 72.00 | 72.00 | 72.00 | 45.42 | 29.07 | 10.09 | 7.42 | 5.68 | 4.49 | 3.63 | 2.52 | 1.85 | |
| | 9.6 | 72.00 | 72.00 | 72.00 | 53.31 | 34.12 | 11.85 | 8.70 | 6.66 | 5.26 | 4.26 | 2.96 | 2.18 | |
| | 10 | 72.00 | 72.00 | 72.00 | 61.82 | 39.57 | 27.48 | 10.09 | 7.73 | 6.11 | 4.95 | 3.43 | 2.52 | |
| | 12 | 72.00 | 72.00 | 72.00 | 72.00 | 51.68 | 35.89 | 26.37 | 10.09 | 7.98 | 6.46 | 4.49 | 3.30 | |
| | 14 | 72.00 | 72.00 | 72.00 | 72.00 | 51.68 | 35.89 | 26.37 | 10.09 | 7.98 | 6.46 | 4.49 | 3.30 | |
| | 16 | 72.00 | 72.00 | 72.00 | 72.00 | 65.40 | 45.42 | 33.37 | 25.55 | 10.09 | 8.18 | 5.68 | 4.17 | |
| | 20 | 72.00 | 72.00 | 72.00 | 72.00 | 69.84 | 48.50 | 35.63 | 27.28 | 10.78 | 8.73 | 6.06 | 4.45 | |
| | 24 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 50.61 | 37.18 | 28.47 | 11.25 | 9.11 | 6.33 | 4.65 | |
| | 28 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 53.85 | 39.57 | 30.29 | 11.97 | 9.69 | 6.73 | 4.95 | |
| | 32 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 56.07 | 41.20 | 31.54 | 24.92 | 10.09 | 7.01 | 5.15 | |
| | 40 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 63.01 | 46.29 | 35.44 | 28.00 | 11.34 | 7.88 | 5.79 | |
| 48 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 65.40 | 48.05 | 36.79 | 29.07 | 11.77 | 8.18 | 6.01 | | |
| 64 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 69.09 | 50.76 | 38.86 | 30.71 | 24.87 | 8.64 | 6.34 | | |
| 80 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 54.48 | 41.71 | 32.96 | 26.70 | 9.27 | 6.81 | | |
| 60,000 | 8.8 | 72.00 | 72.00 | 67.29 | 37.85 | 24.22 | 8.41 | 6.18 | 4.73 | 3.74 | 3.03 | 2.10 | 1.54 | |
| | 9.6 | 72.00 | 72.00 | 72.00 | 44.42 | 28.43 | 9.87 | 7.25 | 5.55 | 4.39 | 3.55 | 2.47 | 1.81 | |
| | 10 | 72.00 | 72.00 | 72.00 | 51.52 | 32.97 | 11.45 | 8.41 | 6.44 | 5.09 | 4.12 | 2.86 | 2.10 | |
| | 12 | 72.00 | 72.00 | 72.00 | 67.29 | 43.07 | 29.91 | 10.99 | 8.41 | 6.65 | 5.38 | 3.74 | 2.75 | |
| | 14 | 72.00 | 72.00 | 72.00 | 67.29 | 43.07 | 29.91 | 10.99 | 8.41 | 6.65 | 5.38 | 3.74 | 2.75 | |
| | 16 | 72.00 | 72.00 | 72.00 | 72.00 | 54.50 | 37.85 | 27.81 | 10.65 | 8.41 | 6.81 | 4.73 | 3.48 | |
| | 20 | 72.00 | 72.00 | 72.00 | 72.00 | 58.20 | 40.42 | 29.69 | 11.37 | 8.98 | 7.27 | 5.05 | 3.71 | |
| | 24 | 72.00 | 72.00 | 72.00 | 72.00 | 60.73 | 42.17 | 30.98 | 11.86 | 9.37 | 7.59 | 5.27 | 3.87 | |
| | 28 | 72.00 | 72.00 | 72.00 | 72.00 | 64.62 | 44.88 | 32.97 | 25.24 | 9.97 | 8.08 | 5.61 | 4.12 | |
| | 32 | 72.00 | 72.00 | 72.00 | 72.00 | 67.29 | 46.73 | 34.33 | 26.28 | 10.38 | 8.41 | 5.84 | 4.29 | |
| | 40 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 52.50 | 38.57 | 29.53 | 11.67 | 9.45 | 6.56 | 4.82 | |
| 48 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 54.50 | 40.04 | 30.66 | 24.22 | 9.81 | 6.81 | 5.01 | | |
| 64 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 57.57 | 42.30 | 32.39 | 25.59 | 10.36 | 7.20 | 5.29 | | |
| 80 | 72.00 | 72.00 | 72.00 | 72.00 | 72.00 | 61.80 | 45.40 | 34.76 | 27.47 | 11.12 | 7.72 | 5.68 | | |
| 100,000 | 8.8 | 72.00 | 52.52 | 40.37 | 11.36 | 7.27 | 5.05 | 3.71 | 2.84 | 2.24 | 1.82 | 1.26 | 0.93 | |
| | 9.6 | 72.00 | 61.63 | 47.38 | 26.65 | 8.53 | 5.92 | 4.35 | 3.33 | 2.63 | 2.13 | 1.48 | 1.09 | |
| | 10 | 72.00 | 71.48 | 54.95 | 30.91 | 9.89 | 6.87 | 5.05 | 3.86 | 3.05 | 2.47 | 1.72 | 1.26 | |
| | 12 | 72.00 | 72.00 | 71.78 | 40.37 | 25.84 | 8.97 | 6.59 | 5.05 | 3.99 | 3.23 | 2.24 | 1.65 | |
| | 14 | 72.00 | 72.00 | 71.78 | 40.37 | 25.84 | 8.97 | 6.59 | 5.05 | 3.99 | 3.23 | 2.24 | 1.65 | |
| | 16 | 72.00 | 72.00 | 72.00 | 51.10 | 32.70 | 11.36 | 8.34 | 6.39 | 5.05 | 4.09 | 2.84 | 2.09 | |
| | 20 | 72.00 | 72.00 | 72.00 | 54.56 | 34.92 | 24.25 | 8.91 | 6.82 | 5.39 | 4.36 | 3.03 | 2.23 | |
| | 24 | 72.00 | 72.00 | 72.00 | 56.93 | 36.44 | 25.30 | 9.30 | 7.12 | 5.62 | 4.55 | 3.16 | 2.32 | |
| | 28 | 72.00 | 72.00 | 72.00 | 60.59 | 38.77 | 26.93 | 9.89 | 7.57 | 5.98 | 4.85 | 3.37 | 2.47 | |
| | 32 | 72.00 | 72.00 | 72.00 | 63.08 | 40.37 | 28.04 | 10.30 | 7.89 | 6.23 | 5.05 | 3.50 | 2.57 | |
| | 40 | 72.00 | 72.00 | 72.00 | 70.88 | 45.36 | 31.50 | 11.57 | 8.86 | 7.00 | 5.67 | 3.94 | 2.89 | |
| 48 | 72.00 | 72.00 | 72.00 | 72.00 | 47.09 | 32.70 | 24.03 | 9.20 | 7.27 | 5.89 | 4.09 | 3.00 | | |
| 64 | 72.00 | 72.00 | 72.00 | 72.00 | 49.74 | 34.54 | 25.38 | 9.72 | 7.68 | 6.22 | 4.32 | 3.17 | | |
| 80 | 72.00 | 72.00 | 72.00 | 72.00 | 53.39 | 37.08 | 27.24 | 10.43 | 8.24 | 6.67 | 4.63 | 3.41 | | |
| 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 | | | | |