

403-9-8, K-9-8 Capacity Chart

Base Capacity		0.33	Top roll diameter		9	Working Length		96	Solving for Material Width in Inches						
									One Pass Rolling!						
Plate Thickness →			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	9.9	96.00	96.00	96.00	96.00	80.29	51.39	35.68	13.11	10.04	7.93	6.42	4.46	3.28	
	10.8	96.00	96.00	96.00	96.00	94.23	60.31	41.88	15.38	11.78	9.31	7.54	5.23	3.85	
	11.25	96.00	96.00	96.00	96.00	96.00	69.94	48.57	35.68	13.66	10.79	8.74	6.07	4.46	
	13.5	96.00	96.00	96.00	96.00	96.00	91.35	63.44	46.61	35.68	14.10	11.42	7.93	5.83	
	15.75	96.00	96.00	96.00	96.00	96.00	91.35	63.44	46.61	35.68	14.10	11.42	7.93	5.83	
	18	96.00	96.00	96.00	96.00	96.00	96.00	80.29	58.99	45.16	35.68	14.45	10.04	7.37	
	22.5	96.00	96.00	96.00	96.00	96.00	96.00	85.73	62.99	48.22	38.10	15.43	10.72	7.87	
	27	96.00	96.00	96.00	96.00	96.00	96.00	89.46	65.72	50.32	39.76	32.21	11.18	8.22	
	31.5	96.00	96.00	96.00	96.00	96.00	96.00	95.20	69.94	53.55	42.31	34.27	11.90	8.74	
	36	96.00	96.00	96.00	96.00	96.00	96.00	96.00	72.83	55.76	44.05	35.68	12.39	9.10	
	45	96.00	96.00	96.00	96.00	96.00	96.00	96.00	81.83	62.65	49.50	40.09	13.92	10.23	
	54	96.00	96.00	96.00	96.00	96.00	96.00	96.00	84.94	65.03	51.39	41.62	14.45	10.62	
72	96.00	96.00	96.00	96.00	96.00	96.00	96.00	89.73	68.70	54.28	43.97	15.27	11.22		
90	96.00	96.00	96.00	96.00	96.00	96.00	96.00	96.00	73.74	58.26	47.19	32.77	12.04		
40,000	9.9	96.00	96.00	96.00	96.00	60.22	38.54	13.38	9.83	7.53	5.95	4.82	3.35	2.46	
	10.8	96.00	96.00	96.00	96.00	70.67	45.23	15.70	11.54	8.83	6.98	5.65	3.93	2.88	
	11.25	96.00	96.00	96.00	96.00	81.96	52.46	36.43	13.38	10.25	8.10	6.56	4.55	3.35	
	13.5	96.00	96.00	96.00	96.00	96.00	68.51	47.58	34.96	13.38	10.57	8.56	5.95	4.37	
	15.75	96.00	96.00	96.00	96.00	96.00	68.51	47.58	34.96	13.38	10.57	8.56	5.95	4.37	
	18	96.00	96.00	96.00	96.00	96.00	86.71	60.22	44.24	33.87	13.38	10.84	7.53	5.53	
	22.5	96.00	96.00	96.00	96.00	96.00	92.59	64.30	47.24	36.17	14.29	11.57	8.04	5.90	
	27	96.00	96.00	96.00	96.00	96.00	96.00	67.09	49.29	37.74	14.91	12.08	8.39	6.16	
	31.5	96.00	96.00	96.00	96.00	96.00	96.00	71.40	52.46	40.16	15.87	12.85	8.92	6.56	
	36	96.00	96.00	96.00	96.00	96.00	96.00	74.34	54.62	41.82	33.04	13.38	9.29	6.83	
	45	96.00	96.00	96.00	96.00	96.00	96.00	83.53	61.37	46.99	37.12	15.04	10.44	7.67	
	54	96.00	96.00	96.00	96.00	96.00	96.00	86.71	63.71	48.78	38.54	15.61	10.84	7.96	
72	96.00	96.00	96.00	96.00	96.00	96.00	91.60	67.30	51.52	40.71	32.98	11.45	8.41		
90	96.00	96.00	96.00	96.00	96.00	96.00	96.00	72.23	55.30	43.70	35.39	12.29	9.03		
50,000	9.9	96.00	96.00	85.64	48.17	15.42	10.71	7.87	6.02	4.76	3.85	2.68	1.97		
	10.8	96.00	96.00	96.00	56.54	36.18	12.56	9.23	7.07	5.58	4.52	3.14	2.31		
	11.25	96.00	96.00	96.00	65.57	41.96	14.57	10.71	8.20	6.48	5.25	3.64	2.68		
	13.5	96.00	96.00	96.00	85.64	54.81	38.06	13.98	10.71	8.46	6.85	4.76	3.50		
	15.75	96.00	96.00	96.00	85.64	54.81	38.06	13.98	10.71	8.46	6.85	4.76	3.50		
	18	96.00	96.00	96.00	96.00	69.37	48.17	35.39	13.55	10.71	8.67	6.02	4.42		
	22.5	96.00	96.00	96.00	96.00	74.07	51.44	37.79	14.47	11.43	9.26	6.43	4.72		
	27	96.00	96.00	96.00	96.00	77.29	53.68	39.43	15.10	11.93	9.66	6.71	4.93		
	31.5	96.00	96.00	96.00	96.00	82.25	57.12	41.96	32.13	12.69	10.28	7.14	5.25		
	36	96.00	96.00	96.00	96.00	85.64	59.47	43.70	33.45	13.22	10.71	7.43	5.46		
	45	96.00	96.00	96.00	96.00	96.00	66.82	49.10	37.59	14.85	12.03	8.35	6.14		
	54	96.00	96.00	96.00	96.00	96.00	69.37	50.97	39.02	15.42	12.49	8.67	6.37		
72	96.00	96.00	96.00	96.00	96.00	73.28	53.84	41.22	32.57	13.19	9.16	6.73			
90	96.00	96.00	96.00	96.00	96.00	78.65	57.79	44.24	34.96	14.16	9.83	7.22			
60,000	9.9	96.00	92.83	71.37	40.14	12.85	8.92	6.55	5.02	3.96	3.21	2.23	1.64		
	10.8	96.00	96.00	83.76	47.11	15.08	10.47	7.69	5.89	4.65	3.77	2.62	1.92		
	11.25	96.00	96.00	96.00	54.64	34.97	12.14	8.92	6.83	5.40	4.37	3.04	2.23		
	13.5	96.00	96.00	96.00	71.37	45.68	15.86	11.65	8.92	7.05	5.71	3.96	2.91		
	15.75	96.00	96.00	96.00	71.37	45.68	15.86	11.65	8.92	7.05	5.71	3.96	2.91		
	18	96.00	96.00	96.00	90.33	57.81	40.14	14.75	11.29	8.92	7.23	5.02	3.69		
	22.5	96.00	96.00	96.00	96.00	61.73	42.87	15.75	12.06	9.53	7.72	5.36	3.94		
	27	96.00	96.00	96.00	96.00	64.41	44.73	32.86	12.58	9.94	8.05	5.59	4.11		
	31.5	96.00	96.00	96.00	96.00	68.54	47.60	34.97	13.39	10.58	8.57	5.95	4.37		
	36	96.00	96.00	96.00	96.00	71.37	49.56	36.41	13.94	11.01	8.92	6.20	4.55		
	45	96.00	96.00	96.00	96.00	80.19	55.69	40.91	15.66	12.37	10.02	6.96	5.11		
	54	96.00	96.00	96.00	96.00	83.24	57.81	42.47	32.52	12.85	10.41	7.23	5.31		
72	96.00	96.00	96.00	96.00	87.93	61.06	44.86	34.35	13.57	10.99	7.63	5.61			
90	96.00	96.00	96.00	96.00	94.39	65.55	48.16	36.87	14.57	11.80	8.19	6.02			
100,000	9.9	83.22	55.70	42.82	12.04	7.71	5.35	3.93	3.01	2.38	1.93	1.34	0.98		
	10.8	96.00	65.37	50.26	14.13	9.05	6.28	4.62	3.53	2.79	2.26	1.57	1.15		
	11.25	96.00	75.81	58.28	32.78	10.49	7.29	5.35	4.10	3.24	2.62	1.82	1.34		
	13.5	96.00	96.00	76.13	42.82	13.70	9.52	6.99	5.35	4.23	3.43	2.38	1.75		
	15.75	96.00	96.00	76.13	42.82	13.70	9.52	6.99	5.35	4.23	3.43	2.38	1.75		
	18	96.00	96.00	96.00	54.20	34.69	12.04	8.85	6.77	5.35	4.34	3.01	2.21		
	22.5	96.00	96.00	96.00	57.87	37.04	12.86	9.45	7.23	5.72	4.63	3.21	2.36		
	27	96.00	96.00	96.00	60.38	38.65	13.42	9.86	7.55	5.96	4.83	3.35	2.46		
	31.5	96.00	96.00	96.00	64.26	41.13	14.28	10.49	8.03	6.35	5.14	3.57	2.62		
	36	96.00	96.00	96.00	66.91	42.82	14.87	10.92	8.36	6.61	5.35	3.72	2.73		
	45	96.00	96.00	96.00	75.18	48.11	33.41	12.27	9.40	7.42	6.01	4.18	3.07		
	54	96.00	96.00	96.00	78.04	49.95	34.69	12.74	9.76	7.71	6.24	4.34	3.19		
72	96.00	96.00	96.00	82.44	52.76	36.64	13.46	10.30	8.14	6.60	4.58	3.36			
90	96.00	96.00	96.00	88.49	56.63	39.33	14.45	11.06	8.74	7.08	4.92	3.61			
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					9.90					
					Mild Steel, i.e. M-1020, A-36 - ID					11.25					
					CR Sheet, Thin Galvanized, Half Hard Copper, SS -ID					13.50					
					AR Plate, T-1, Other Super Alloys - ID					18.00					