



404-24-10 Prebend Capacity Chart

Base Capacity	2.375	Top roll diameter	24	Working Length	120	Solving for Material Width in Inches										
						One Pass Rolling!										
Plate Thickness →		1"	1-1/8"	1-1/4"	1-3/8"	1-1/2"	1-3/4"	1-7/8"	2"	2-1/8"	2-1/4"	2-3/8"	2-1/2"	2-5/8"	2-3/4"	
Yield Strength PSI ↓	ID (in) ↓	1	1.125	1.25	1.375	1.5	1.75	1.875	2	2.125	2.25	2.375	2.5	2.625	2.75	
30,000	26.4	120.00	120.00	120.00	120.00	120.00	106.09	92.42	81.23	71.95	64.18	57.60	51.98	47.15	42.96	
	28.8	120.00	120.00	120.00	120.00	120.00	120.00	108.46	95.33	84.44	75.32	67.60	61.01	55.34	50.42	
	30	120.00	120.00	120.00	120.00	120.00	120.00	120.00	110.56	97.93	87.35	78.40	70.76	64.18	58.48	
	36	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	114.09	102.40	92.42	83.82	76.38	
	42	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	114.09	102.40	92.42	83.82	76.38	
	48	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	116.96	106.09	96.66	
	60	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	113.28	103.22	
	72	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	118.20	107.70	
	84	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	114.61	
	96	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	119.34	
	120	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	
	144	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	
192	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00		
240	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00		
40,000	26.4	120.00	120.00	120.00	120.00	108.30	79.57	69.31	60.92	53.96	48.13	43.20	19.49	17.68	16.11	
	28.8	120.00	120.00	120.00	120.00	120.00	93.38	81.35	71.49	63.33	56.49	50.70	45.76	41.50	18.91	
	30	120.00	120.00	120.00	120.00	120.00	108.30	94.34	82.92	73.45	65.51	58.80	53.07	48.13	43.86	
	36	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.30	95.93	85.57	76.80	69.31	62.87	57.28	
	42	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.30	95.93	85.57	76.80	69.31	62.87	57.28	
	48	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.30	97.20	87.72	79.57	72.50	
	60	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	115.64	103.79	93.67	84.96	77.41	
	72	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.30	97.74	88.65	80.78	
	84	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	115.25	104.01	94.34	85.96	
	96	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.30	98.23	89.50	
	120	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	110.37	100.57	
	144	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	114.58	104.40	
192	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	110.28		
240	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	118.37		
50,000	26.4	120.00	120.00	120.00	103.11	86.64	63.65	55.45	48.74	43.17	19.25	17.28	15.60	14.15	12.89	
	28.8	120.00	120.00	120.00	120.00	101.68	74.70	65.08	57.20	50.66	45.19	40.56	18.30	16.60	15.13	
	30	120.00	120.00	120.00	120.00	117.93	86.64	75.47	66.33	58.76	52.41	47.04	42.45	19.25	17.54	
	36	120.00	120.00	120.00	120.00	120.00	113.16	98.58	86.64	76.75	68.46	61.44	55.45	50.29	45.83	
	42	120.00	120.00	120.00	120.00	120.00	113.16	98.58	86.64	76.75	68.46	61.44	55.45	50.29	45.83	
	48	120.00	120.00	120.00	120.00	120.00	120.00	120.00	109.65	97.13	86.64	77.76	70.18	63.65	58.00	
	60	120.00	120.00	120.00	120.00	120.00	120.00	120.00	117.09	103.72	92.51	83.03	74.93	67.97	61.93	
	72	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.23	96.53	86.64	78.19	70.92	64.62	
	84	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	115.17	102.73	92.20	83.21	75.47	68.77	
	96	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	119.92	106.96	96.00	86.64	78.59	71.60	
	120	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	107.87	97.35	88.30	80.45	
	144	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	111.97	101.06	91.66	
192	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	118.28	106.75	96.82		
240	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	114.58	103.93	94.70		
60,000	26.4	120.00	120.00	103.97	85.92	72.20	53.04	46.21	40.61	17.99	16.04	14.40	13.00	11.79	10.74	
	28.8	120.00	120.00	120.00	100.84	84.73	62.25	54.23	47.66	42.22	18.83	16.90	15.25	13.83	12.61	
	30	120.00	120.00	120.00	116.95	98.27	72.20	62.89	55.28	48.97	43.68	19.60	17.69	16.04	14.62	
	36	120.00	120.00	120.00	120.00	120.00	94.30	82.15	72.20	63.96	57.05	51.20	46.21	41.91	19.09	
	42	120.00	120.00	120.00	120.00	120.00	94.30	82.15	72.20	63.96	57.05	51.20	46.21	41.91	19.09	
	48	120.00	120.00	120.00	120.00	120.00	119.35	103.97	91.38	80.94	72.20	64.80	58.48	53.04	48.33	
	60	120.00	120.00	120.00	120.00	120.00	120.00	111.01	97.57	86.43	77.09	69.19	62.45	56.64	51.61	
	72	120.00	120.00	120.00	120.00	120.00	120.00	115.84	101.81	90.19	80.45	72.20	65.16	59.10	53.85	
	84	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.35	95.97	85.61	76.83	69.34	62.89	57.31	
	96	120.00	120.00	120.00	120.00	120.00	120.00	120.00	112.81	99.93	89.14	80.00	72.20	65.49	59.67	
	120	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	112.28	100.15	89.89	81.12	73.58	67.04	
	144	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	116.56	103.97	93.31	84.21	76.38	69.60	
192	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	109.82	98.57	88.96	80.69	73.52		
240	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	117.88	105.80	95.48	86.61	78.91		
100,000	26.4	97.47	77.01	62.38	51.55	43.32	15.91	13.86	12.18	10.79	9.63	8.64	7.80	7.07	6.44	
	28.8	114.39	90.38	73.21	60.50	50.84	18.68	16.27	14.30	12.67	11.30	10.14	9.15	8.30	7.56	
	30	120.00	104.82	84.91	70.17	58.96	43.32	18.87	16.58	14.69	13.10	11.76	10.61	9.63	8.77	
	36	120.00	120.00	110.90	91.65	77.01	56.58	49.29	43.32	19.19	17.11	15.36	13.86	12.57	11.46	
	42	120.00	120.00	110.90	91.65	77.01	56.58	49.29	43.32	19.19	17.11	15.36	13.86	12.57</		