



404-21-10 Prebend Capacity Chart

Base Capacity	1.75	Top roll diameter		21	Working Length				120	Solving for Material Width in Inches						
		3/4"	7/8"		1"	1-1/8"	1-1/4"	1-3/8"		1-1/2"	One Pass Rolling!					
Plate Thickness →		0.75	0.875	1	1.125	1.25	1.375	1.5	1.75	1.875	2	2.125	2.25	2.375	2.5	
Yield Strength PSI ↓	ID (in) ↓	23.1	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	
30,000	25.2	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	
	26.25	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	
	31.5	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	
	36.75	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	
	42	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	
	52.5	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	
	63	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	
	73.5	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	
	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	120.00	
	105	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	
	126	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	
	168	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	
210	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	23.1	120.00	120.00	120.00	104.53	84.67	69.98	58.80	43.20	18.82	16.54	14.65	13.07	11.73	10.58	
	25.2	120.00	120.00	120.00	120.00	99.37	82.13	69.01	50.70	44.17	19.41	17.19	15.34	13.76	12.42	
	26.25	120.00	120.00	120.00	120.00	115.25	95.25	80.03	58.80	51.22	45.02	19.94	17.79	15.96	14.41	
	31.5	120.00	120.00	120.00	120.00	120.00	120.00	120.00	104.53	76.80	66.90	58.80	52.09	46.46	41.70	
	36.75	120.00	120.00	120.00	120.00	120.00	120.00	120.00	104.53	76.80	66.90	58.80	52.09	46.46	41.70	
	42	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	97.20	84.67	74.42	65.92	58.80	52.77	
	52.5	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	103.79	90.41	79.46	70.39	62.79	56.35	
	63	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	108.30	94.34	82.92	73.45	65.51	58.80	
	73.5	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	115.25	100.39	88.24	78.16	69.72	62.57	
	84	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	104.53	91.88	81.38	72.59	65.15	
	105	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	117.45	103.23	91.44	81.57	73.21	
	126	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	107.16	94.93	84.67	75.99	
168	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	113.20	100.27	89.44	80.27		
210	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	107.63	96.00	86.16		
50,000	23.1	120.00	120.00	105.84	83.63	67.74	55.98	47.04	17.28	15.05	13.23	11.72	10.45	9.38	8.47	
	25.2	120.00	120.00	120.00	98.15	79.50	65.70	55.21	40.56	17.67	15.53	13.75	12.27	11.01	9.94	
	26.25	120.00	120.00	120.00	113.83	92.20	76.20	64.03	47.04	40.98	18.01	15.95	14.23	12.77	11.52	
	31.5	120.00	120.00	120.00	120.00	120.00	120.00	99.52	83.63	61.44	53.52	47.04	41.67	18.58	16.68	
	36.75	120.00	120.00	120.00	120.00	120.00	120.00	99.52	83.63	61.44	53.52	47.04	41.67	18.58	16.68	
	42	120.00	120.00	120.00	120.00	120.00	120.00	120.00	105.84	77.76	67.74	59.54	52.74	47.04	42.22	
	52.5	120.00	120.00	120.00	120.00	120.00	120.00	120.00	113.01	83.03	72.33	63.57	56.31	50.23	45.08	
	63	120.00	120.00	120.00	120.00	120.00	120.00	120.00	117.93	86.64	75.47	66.33	58.76	52.41	47.04	
	73.5	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	92.20	80.32	70.59	62.53	55.77	50.06	
	84	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	96.00	83.63	73.50	65.11	58.07	52.12	
	105	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	107.87	93.96	82.58	73.15	65.25	58.56	
	126	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	111.97	97.54	85.73	75.94	67.74	60.79	
168	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	118.28	103.04	90.56	80.22	71.55	64.22		
210	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	110.60	97.20	86.10	76.80	68.93		
60,000	23.1	120.00	115.20	88.20	69.69	56.45	46.65	19.60	14.40	12.54	11.03	9.77	8.71	7.82	7.06	
	25.2	120.00	120.00	103.51	81.79	66.25	54.75	46.01	16.90	14.72	12.94	11.46	10.22	9.18	8.28	
	26.25	120.00	120.00	120.00	94.85	76.83	63.50	53.36	19.60	17.07	15.01	13.29	11.86	10.64	9.60	
	31.5	120.00	120.00	120.00	120.00	100.35	82.94	69.69	51.20	44.60	19.60	17.36	15.49	13.90	12.54	
	36.75	120.00	120.00	120.00	120.00	100.35	82.94	69.69	51.20	44.60	19.60	17.36	15.49	13.90	12.54	
	42	120.00	120.00	120.00	120.00	120.00	104.97	88.20	64.80	56.45	49.61	43.95	19.60	17.59	15.88	
	52.5	120.00	120.00	120.00	120.00	120.00	112.08	94.18	69.19	60.27	52.98	46.93	41.86	18.78	16.95	
	63	120.00	120.00	120.00	120.00	120.00	116.95	98.27	72.20	62.89	55.28	48.97	43.68	19.60	17.69	
	73.5	120.00	120.00	120.00	120.00	120.00	120.00	104.58	76.83	66.93	58.82	52.11	46.48	41.71	18.82	
	84	120.00	120.00	120.00	120.00	120.00	120.00	108.89	80.00	69.69	61.25	54.26	48.40	43.43	19.60	
	105	120.00	120.00	120.00	120.00	120.00	120.00	120.00	89.89	78.30	68.82	60.96	54.38	48.80	44.05	
	126	120.00	120.00	120.00	120.00	120.00	120.00	120.00	93.31	81.29	71.44	63.28	56.45	50.66	45.72	
100,000	168	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	98.57	85.86	75.47	66.85	59.63	53.52	
	210	120.00	120.00	120.00	120.00	120.00	120.00	120.00	120.00	105.80	92.16	81.00	71.75	64.00	57.44	
	23.1	94.08	69.12	52.92	41.81	16.93	14.00	11.76	8.64	7.53	6.62	5.86	5.23	4.69	4.23	
	25.2	110.41	81.12	62.11	49.07	19.87	16.43	13.80	10.14	8.83	7.76	6.88	6.13	5.51	4.97	
	26.25	120.00	94.08	72.03	56.91	46.10	19.05	16.01	11.76	10.24	9.00	7.98	7.11	6.38	5.76	
	31.5	120.00	120.00	94.08	74.33	60.21	49.76	41.81	15.36	13.38	11.76	10.42	9.29	8.34	7.53	
	36.75	120.00	120.00	94.08	74.33	60.21	49.76	41.81	15.36	13.38	11.76	10.42	9.29	8.34	7.53	
	42	120.00	120.00	119.07	94.08	76.20	62.98									