







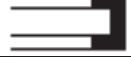







302HV / CPHV50 Capacities & Specifications Chart

Material Type	Shape	Max. Section Size	Min. Suggested ID ¹
Flats, Hard		2 × 5/16 in. / 50 × 8 mm	16 in. / 400 mm
Flats, Easy		2 3/8 × 5/8 in. / 60 × 16 mm	18 in. / 450 mm
Square Bar		1 in. / 25 mm	12 in. / 300 mm
Angle, Leg-Out		2 × 3/16 in. / 50 × 5 mm	24 in. / 600 mm
Angle, Leg-In		1 1/2 × 3/16 in. / 40 × 5 mm	18 in. / 450 mm
Tee, Leg-Out		2 × 1/4 in. / 50 × 6 mm	20 in. / 500 mm
Tee, Leg-In		1 1/2 × 3/16 in. / 40 × 5 mm	20 in. / 500 mm
C, Legs-Out		2 × 1 1/2 in. / 50 × mm	16 in. / 400 mm
C, Legs-In		2 × 1 in. / 50 × 25 mm	20 in. / 500 mm
Round Bar		Ø1 3/16 in. / 30 mm	14 in. / 350 mm
Pipe, Schedule 40 ²		Ø1 1/4 in. / 32 mm	20 in. / 500 mm
Round Tube ²		2 in. / 50 mm × 16Ga	
Square Tube ³		1 1/2 in. / 40 mm × 14Ga	
Rectangular Tube ³		1 1/2 in. / 40 mm × 3/4 in. / 20 mm × 13Ga	

Section Modulus	0.20 in ³ / 3.5 cm ³	Roll Diameters	5.70 in. / 145mm	Usable Shaft	3 3/8 in. / 85 mm
Rolling Speed	20 fpm / 5.5 mpm	Shaft Diameters	1.57 in. / 40mm	Thread Length	1 7/8 in. / 48 mm
Power Output	3.8 HP / 2.8 kW	Approx. Weight	1200 lbs. / 495 kg	Shaft O.D.	1 1/16 in. / 40 mm
Key Width	15/32 in. / 11.77 mm	Total Shaft Height	1 5/8 in. / 42.4 mm	Overall Roll O.D.	5 25/32 in. / 147 mm

Rev.0 05/2014. (1.) Minimum suggested internal diameter applies to maximum section size as listed at left. (2.) Set of three rolls required for each tube and pipe size. (3.) Special rolls may improve results on these profile. (4.) Special Beam On-Edge Traction Device required. (5.) With standard equipment.

This chart indicates minimum suggested inside diameter with maximum profile size, using mild steel rolling generally in multiple passes. Custom tooling for some profiles may be required for volume production and minimum rolling diameters are limited to level of acceptable deformation. The manufacturer and Carell Corporation reserves the right to revise design, construction and specifications without prior notice. Ratings based on material yield on 36KSI. Machines with extended or shortened shafts are available. Series 3000/CPHV machines are designed compliant with ANSI B11.12.1996 standards. The employer of the operator is responsible for providing and insuring the usage of point of operation guards and/or properly applied and adjusted point of operation safety devices are required to meet OSHA, state and local safety requirements.

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