

306HV / CPHV90 Capacities & Specifications Chart

Material Type	Shape	Max. Section Size	Min. Suggested ID ¹
Flats, Hard		4 × 5/8 in. / 100 × 25 mm	42 in. / 1,070 mm
Flats, Easy		6 × 1 in. / 150 × 35 mm	30 in. / 760 mm
Square Bar		2 in. / 60 mm	26 in. / 660 mm
Angle, Leg-Out		3 1/2 × 3/8 in. / 90 × 10 mm	48 in. / 1,220 mm
Angle, Leg-In		3 × 3/8 in. / 80 × 10 mm	40 in. / 1,020 mm
Tee, Leg-Out		3 1/2 × 3/8 in. / 90 × 10 mm	38 in. / 965 mm
Tee, Leg-In		3 1/2 × 5/16 in. / 90 × 9 mm	38 in. / 965 mm
C, Legs-Out		6 × 2 1/2 in. / 160 × 65 mm	30 in. / 760 mm
C, Legs-In		5 × 2 1/2 in. / 140 × 65 mm	40 in. / 1,020 mm
Round Bar		Ø2 1/2 in. / 65 mm	30 in. / 760 mm
Pipe, Schedule 40 ²		Ø3 in. / 80 mm	42 in. / 1,070 mm
Round Tube ²		4 1/2 in. / 115 mm × 12Ga	
Square Tube ³		3 × 3/16 in. / 80 × 8 mm	
Rectangular Tube ³		4 × 1 1/2 × 3/16 in. 100 × 40 × 8 mm	
I-Beam, EZ		S6 × 17 in. / 160 × 74 mm	36 in. / 915 mm
H-Beam, EZ		M4 × 13 in. / HEA 100	72 in. / 1,830 mm

Section Modulus	1.5-2.26 in ³ / 28-40 cm ³	Roll Diameters	10.83 in. / 280 mm	Usable Shaft	7 1/4 in. / 185 mm
Rolling Speed	0-23 fpm / 0-7 mpm	Shaft Diameters	3.54 in. / 85 mm	Thread Length	3 3/8 in. / 85 mm
Power Output	10 HP / 7.5 kW	Approx. Weight	5,725 lbs. / 2,600 kg	Shaft O.D.	3 1/2 in. / 90 mm
Key Width	7/8 in. / 22 mm	Total Shaft Height		Overall Roll O.D.	10 7/8 in. / 275 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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