

308HV / CPHV120 Capacities & Specifications Chart

Material Type	Shape	Max. Section Size	Min. Suggested ID ¹
Flats, Hard		5½ × ¾ in. / 150 × 30 mm	60 in. / 1,525 mm
Flats, Easy		8 × 2 in. / 240 × 40 mm	42 in. / 1,065 mm
Square Bar		3 in. / 85 mm	36 in. / 915 mm
Angle, Leg-Out		5 × ½ in. / 120 × 15 mm	60 in. / 1,525 mm
Angle, Leg-In		4 × ½ in. / 100 × 12 mm	48 in. / 1,220 mm
Tee, Leg-Out		4½ × ½ in. / 120 × 13 mm	48 in. / 1,220 mm
Tee, Leg-In		4 × ½ in. / 100 × 11 mm	50 in. / 1,270 mm
C, Legs-Out		8 × 3 in. / 220 × 80 mm	36 in. / 915 mm
C, Legs-In		8 × 3 in. / 220 × 80 mm	48 in. / 1,220 mm
Round Bar		Ø3¾ in. / 90 mm	40 in. / 1,015 mm
Pipe, Schedule 40 ²		Ø5 in. / 140 mm	70 in. / 1,780 mm
Round Tube ²		6½ in. / 170 mm × 9Ga	
Square Tube ³		4 × ⅝ in. / 120 × 6 mm	
Rectangular Tube ³		5½ × 2 × ⅝ in. 150 × 80 × 6 mm	
I-Beam, EZ		S8 × 23 in. / 220 × 98 mm	48 in. / 1,220 mm
H-Beam, EZ		W6 × 20 in. / HEA 160	60 in. / 1,525 mm
C-Beam, On Edge ⁴		C5 × 9 in. / 140 × 60 mm	140 in. / 356 cm
I-Beam, HW ⁴		S6 × 17 in. / 160 × 82 mm	120 in. / 305 cm
H-Beam, HW ⁴		W4 × 13 in. / HEA 120	100 in. / 254 cm

Section Modulus	4.3-7.4 in ³ / 70-120 cm ³	Roll Diameters	15.375 in. / 390 mm	Usable Shaft	9 in. / 230 mm
Rolling Speed	0-23 fpm / 0-7 mpm	Shaft Diameters	5.3/4.7 in. / 135/120 mm	Thread Length	4.25 in. / 108 mm
Power Output	20 HP / 15 kW	Approx. Weight	10,000 lbs. / 4,450 kg	Shaft O.D.	4.75 in. / 120 mm
Key Width	1.25 in. / 32 mm	Total Shaft Height	5 in. / 127.5 mm	Overall Roll O.D.	15.375 in. / 390 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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