

PREBENDING CAPACITY CHART



MODEL: **MCB E-30**

Inside cylinder can Ø versus plate width and thickness

Material; **Mild Steel S355JR**
 with max. Ultimate Tensile Strength, up to: **500 MPa**
 and with max. Elastic Yield Point up to : **360 MPa**

Plate Width (mm)	Shell Inside Diameter (mm)				
	380 *	510 *	680	1020	1700
1200	15	16	17	17	21
1350	14	15	15	15	18
1500	13	13	13	14	17
1650	12	12	12	13	16
1800	11	12	12	12	15
1950	11	11	11	11	14
2100	10	11	11	11	13
2250	10	10	11	11	13
2400	10	10	10	11	12
2550	9	10	10	10	12
2700	9	10	10	10	12
2850	9	10	10	10	12
3000	9	10	10	10	12

Plate Thickness (mm)

These capacities, in multiple passes, are approximated and depends by many factors and conditions. Plates narrower than above, could generate concentrated overloads on small rolls surface sections They are more accurate having more factors available (Material, UTS and Elastic Yield). Missing data increase the approximation and can make the calculated performances inaccurate. The Manufacturer responsibility is limited to performances specifically stated on the contract, and not presumed by these charts, based on theoretical calculations, approximate and not binding. * The diameters (especially the tighter) are approximate. They do not commit the manufacturer responsibility, as they are calculated on the machine power only. The material spring back could in fact re-open the calculated and rolled cylinders to larger diameters, out of the machine power and control. The thinner is the plate and the more its spring back re-opens the rolled diameters. Cones applications reduces the a.m. capacities.