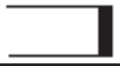
309HV Capacities & Specifications Chart

Material Type	Shape	Max. Section Size	Min. Suggested ID [1]
Flats, Hard		6 × 1 in. / 160 × 40 mm	60 in. / 1,525 mm
Flats, Easy		9 × 2 in. / 260 × 50 mm	48 in. / 1,220 mm
Square Bar		3⅜ in. / 100 mm	48 in. / 1,220 mm
Angle, Leg-Out		5 × ⅝ in. / 130 × 15 mm	54 in. / 1,375 mm
Angle, Leg-In		5 × ½ in. / 130 × 12 mm	60 in. / 1,525 mm
Tee, Leg-Out		5 × ½ in. / 130 × 12 mm	60 in. / 1,525 mm
Tee, Leg-In		4½ × ½ in. / 115 × 12 mm	60 in. / 1,525 mm
C, Legs-Out		10 × 3 in. / 260 × 80 mm	48 in. / 1,220 mm
C, Legs-In		10 × 3 in. / 260 × 80 mm	60 in. / 1,525 mm
Round Bar		Ø3½ in. / 90 mm	40 in. / 1,015 mm
Pipe, Schedule 40 [2]		Ø6 in. / 155 mm	120 in. / 305 cm
Round Tube [2]		7 × 3/16 in. / 180 × 5 mm	
Square Tube [3]		5 × 5/16 in. / 130 × 8 mm	
Rectangular Tube [3]		6 × 3 × ¼ in. 155 × 80 × 7 mm	
I-Beam, EZ		S10 × 35 in. / 260 × 113 mm	48 in. / 1,220 mm
H-Beam, EZ		W8 × 24 in. / HEA 180	72 in. / 1,830 mm
C-Beam, On Edge [4]		C6 × 13 in. / 160 × 65 mm	200 in. / 508 cm
I-Beam, HW [4]		S7 × 20 in. / 180 × 91 mm	150 in. / 381 cm
H-Beam, HW [4]		W5 × 19 in. / HEA 140	100 in. / 254 cm

Section Modulus	6.2-10 in³ / 100-160 cm³	**Roll Diameters**	17 in. / 430 mm	**Usable Shaft**	10.83 in. / 275 mm
Rolling Speed	0-23 fpm / 0-7 mpm	**Shaft Diameters**	6.3/5.3 in. / 155/135 mm	**Thread Length**	5.71 in. / 145 mm
Power Output	24 HP / 18.5 kW	**Approx. Weight**	15,180 lbs. / 6,700 kg	**Shaft O.D.**	5.31 in. / 135 mm
Key Width	1.42 in. / 36 mm	**Total Shaft Height**	5.65 in. / 143.4 mm	**Overall Roll O.D.**	17 in. / 430 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 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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