

310HV4 Capacities & Specifications Chart

Material Type	Shape	Max. Section Size
Flats, Hard		7 × 1¼ in. Ø80
Flats, Easy		10 × 2½ in. Ø48
Square Bar		4 in. Ø50
Angle, Leg-Out		6 × ¾ in. Ø70
Angle, Leg-In		5 × ⅝ in. Ø70
Tee, Leg-Out		WT6 Ø60
Tee, Leg-In		WT6 Ø72
C, Legs-Out		MC12 × 50 in. Ø48
C, Legs-In		MC12 × 50 in. Ø60
Round Bar		4½ in. Ø50
Pipe ¹		6 in. Sch 80 Ø80
Round Tube ¹		8 × ¼ in. Ø250
Square Tube ²		5½ × ⅜ in.
Rectangular Tube ²		7 × 5 × ⅜ in.
I-Beam, EZ		S12 × 35 in. Ø48
H-Beam, EZ		W8 × 31 in. Ø48
C-Beam, On Edge ³		MC7 × 17.6 in. Ø250
I-Beam, HW ³		S8 × 23 in. Ø200
H-Beam, HW ³		W6 × 20 in. Ø180

Section Modulus	9-15 [cm ³] 160 - 270	Roll Diameters	18¾ in. / 476.25mm	Usable Shaft	10.83 in. / 275 mm
Rolling Speed	0-23 fpm / 0-7 mpm	Shaft Diameters	7.2/6.7 in. / 185 / 170 mm	Thread Length	5.71 in. / 145 mm
Power Output	30 HP / 22KW	Approx. Weight	20,500 lbs. / 9200kg	Shaft O.D.	5.31 in. / 135 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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