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# Bar and Angle Rolling Capabilities

| SECTION                          | DESCRIPTION                             | MINIMUM DIAMETER |
|----------------------------------|---|------------------|
| ANGLE - EASY WAY                 | Max. - 5" X 5" X 1/2" OR 6" X 4" X 3/8" | 63" ID           |
|                                  | Min. - 1-1/2" x 1-1/2" x 1/4"           | 32" ID           |
| ANGLE - HARD WAY                 | Max. - 4" X 4" X 5/8" OR 5" X 3" X 3/8" | 80" ID           |
|                                  | Min. - 1-1/2" x 1-1/2" x 1/4"           | 36" ID           |
| PIPE                             | 3/4" Schedule 10S and Schedule 40S      | 16" CL           |
|                                  | 3/4" Schedule 80S                       | 18" CL           |
|                                  | 3/4" Schedule 160S                      | 20" CL           |
|                                  | 1" Schedule 10S and Schedule 40S        | 17" CL           |
|                                  | 1" Schedule 80S                         | 20" CL           |
|                                  | 1" Schedule 160S                        | 22" CL           |
|                                  | 1-1/4" Schedule 10S and Schedule 40S    | 18" CL           |
|                                  | 1-1/4" Schedule 80S                     | 22" CL           |
|                                  | 1-1/4" Schedule 160S                    | 24" CL           |
|                                  | 1-1/2" Schedule 10S and Schedule 40S    | 20" CL           |
|                                  | 1-1/2" Schedule 80S                     | 24" CL           |
|                                  | 1-1/2" Schedule 160S                    | 27" CL           |
|                                  | 2" Schedule 10S and Schedule 40S        | 24" CL           |
|                                  | 2" Schedule 80S                         | 27" CL           |
|                                  | 2" Schedule 160S                        | 30" CL           |
|                                  | 2-1/2" Schedule 10S and Schedule 40S    | 30" CL           |
|                                  | 2-1/2" Schedule 80S                     | 36" CL           |
|                                  | 2-1/2" Schedule 160S                    | 42" CL           |
|                                  | 3" Schedule 10S and Schedule 40S        | 36" CL           |
|                                  | 3" Schedule 80S                         | 48" CL           |
| 3" Schedule 160S                 | 60" CL                                  |                  |
| 4" Schedule 10S and Schedule 40S | 50" CL                                  |                  |
| 4" Schedule 80S                  | 96" CL                                  |                  |
| ROUND BAR                        | Max. - 3" Diameter                      | 30" ID           |
|                                  | Min. - 1/2" Diameter                    | 16" ID           |
| SQUARE BAR                       | Max. - 2-1/2" x 2-1/2"                  | 40" ID           |
|                                  | Min. - 1/2" x 1/2"                      | 16" ID           |
| FLAT BAR - EASY WAY              | Max. - 8" x 1-1/2" or 5" x 2"           | 32" ID           |
|                                  | Min. - 1" X 1/2"                        | 16" ID           |
| FLAT BAR- HARD WAY               | Max. - 5" x 3/4" or 6" x 1/2"           | 50" ID           |
|                                  | Min. - 1/2" x 1/4" Up to 3" x 1-1/2"    | 18" ID           |
| CHANNEL - EASY WAY               | Max. - 10" x 2-5/8" @ 30.0#             | 70" ID           |
|                                  | Min. - 3" x 1-1/2" @ 4.1#               | 30" ID           |
| CHANNEL - HARD WAY               | Max. - 10" x 2-5/8" @ 30.0#             | 70" ID           |
|                                  | Min. - 3" x 1-1/2" @ 4.1#               | 30" ID           |

### Available Materials

#### Stainless steel

- 300 series: 304/304L, 316/316L, 317/317L, 304H, 309S, 310S, 347
- 400 series: 409, 410, 410S, 430
- 200 series: 201, 201L
- Duplex: 2205, 2507, 2101

#### Alloys

- Pure Nickel: 200, 201
- Monel®: 400, 401
- Inconel®: 600, 601, 625
- Incoloy®: 800, 800H, 825
- Hastelloy®: C-276, C-22®, C-2000®, B, B-2, B-3®, G, G-3, G-30®
- Nickel Alloy: Alloy 20, 20Cb3®, 904L
- 6-Moly: AL-6XN®, 254SMO®, 926-MO®, 1925hMO®, SSC-6MO, 25-6MO

#### Reactive/Exotic

- Titanium: Grades 1, 2, 3, 7, 12
- Zirconium: Grades 702, 705

Maximum Sectional Modulus Forming Capacity = (w² x t)/6 = 3.20 in.³

Maximum Width To Thickness Ratio of Flat Bar Formed Hard Way Is 12X

For Alloy Materials—Please Call

#### To learn more

Visit our website: [www.cmc-letco.com](http://www.cmc-letco.com)  
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