STEEL PROCESSING SERVICES

SECTION ROLLING

Channels I Beams I Columns I Angles I Pipe I RHS I Flat Bar

With a proven track record since 1981, Rollco is an Australian leader in steel processing, specialising in cold roll bending and pressing of sectional and plate steel.

Our advanced facility in Sydney's south-western suburbs is the heart of our operations, where we are proud to boast industry-leading machinery and a team of skilled experts dedicated to delivering outstanding outcomes. As part of the Southern Steel Group, we also leverage the resources and capabilities of Australia's largest independent steel distribution and processing network.

At Rollco, every project receives a bespoke approach, delivering tailored solutions that meet the distinct needs of each client. Our high level of customisation in section curving, plate rolling, and brake pressing ensures we can accommodate the unique requirements of diverse projects.

As leaders in steel shaping, our reputation is unparalleled in the steel processing industry. Our projects showcase our expertise, and our team is dedicated to bringing our clients' visions to life. When you partner with us, we're more than just a supplier – we're an extension of your team.

PROCESS

Section rolling, or ring rolling, is a cold roll bending technique, globally recognised as the most economical method for bending structural steel shapes like beams, channels, angles, tubes, or pipes into curves, arcs, or spirals.

MIN. RADII

This recommended minimum radius is based on our 35+ years of experience and customer feedback, ensuring a reliable and effective curving process for each section.

When cold rolling materials, changes in section profile are common, so customers should ensure that the integrity of the finished product is suitable for their individual specifications. As a general rule, the thicker the material, the less deformation or ovality present.

LEAD IN/OUT

Section rolling requires additional material on each end of the curve, which is sometimes referred to as green or grab. As standard practice, this material is left on the job for later removal by the customer.

CAPACITY

Rollco boasts some of the most advanced and largest machinery in Australia, with the capacity to roll the full range of hot rolled sections available locally.

Our CNC capability delivers precise, repeatable results at a competitive price, ensuring accuracy and value for your project.

In addition to standard materials, we can curve cold-formed sections, stainless steel, aluminum, and brass, catering to diverse project requirements.

CAPACITY TABLES

The following tables are intended as a guide only. All customers are encouraged to seek an engineer's advice on the suitability for specific applications. Tighter radius bends are achievable but excessive deformation or ovality may occur. Individual specifications should be quoted when enquiring.

In addition to the nominated sections within the tables, rail, tee section, round bar, billets and multiple radii curved (elliptical) are also available.

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STEEL PROCESSING SERVICES

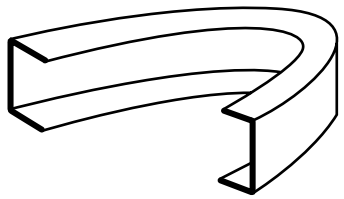
SECTION ROLLING

Channels I Beams I Columns I Angles I Pipe I RHS I Flat Bar

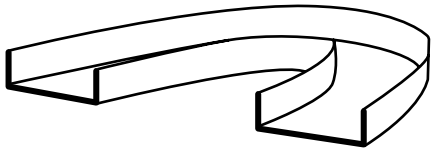
Channels (PFC)

- Also available rolled with a helix for spiral staircase stringers.

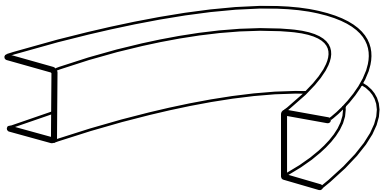
TOE IN



ON EDGE



TOE OUT



Section	Min. Radii	Lead In/Out	Min. Radii	Lead In/Out
75x40 PFC	6000	450	300	500
100x50 PFC	2000	700	350	550
125x65 PFC	2100	700	500	500
150x75 PFC	2200	750	600	750
180x75 PFC	2400	750	700	750
200x75 PFC	3000	700	900	750
230x75 PFC	5000	700	1000	750
250x90 PFC	6000	750	1200	750
300x90 PFC	9300	750	1200	750
380x100 PFC	19000	1000	1500	750

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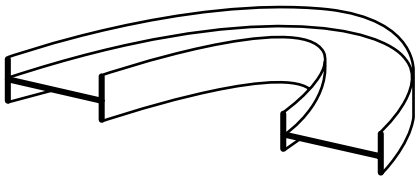
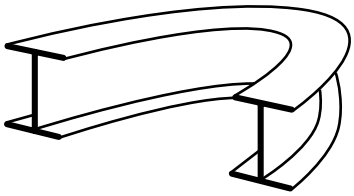
STEEL PROCESSING SERVICES

SECTION ROLLING

Channels I Beams I Columns I Angles I Pipe I RHS I Flat Bar

Beams

- 800WB will not fit in machines on edge.

	ON EDGE		MONORAIL	
				
Section	**Min. Radii**	**Lead In/Out**	**Min. Radii**	**Lead In/Out**
100x45 TFB	1200	650	500	450
125x65 TFB	2500	650	600	500
150 UB 18	1500	650	700	600
180 UB 22	1300	750	900	500
200 UB 18	8000	-	-	-
200 UB 25	4500	750	1000	600
200 UB 30	2200	750	1000	600
250 UB 31	7000	750	1000	700
250 UB 37	3600	800	1000	700
310 UB 32	14500	800	1500	750
310 UB 40	8000	800	1500	750
310 UB 46	4800	950	1500	750
360 UB 44	8300	1000	2000	750
360 UB 57	6400	1000	2000	750
410 UB 60	8000	1000	2500	850
460 UB 67	15000	1000	2500	850
460 UB 74	13000	1000	2500	850
530 UB 92	18000	1000	2500	850
610 UB 101	25000	1000	3000	850
610 UB 125	22000	1000	2500	850
700 WB	-	-	3000	850
1000 WB 322	-	-	4500	1000

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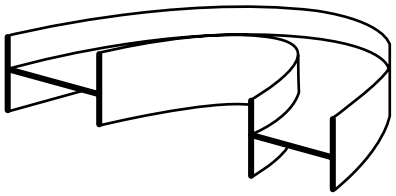
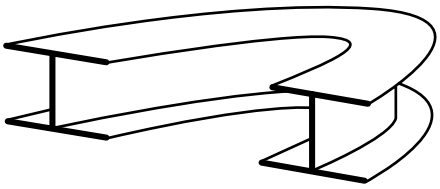
STEEL PROCESSING SERVICES

SECTION ROLLING

Channels I Beams I Columns I Angles I Pipe I RHS I Flat Bar

Columns

	ON EDGE		MONORAIL	
				
Section	**Min. Radii**	**Lead In/Out**	**Min. Radii**	**Lead In/Out**
100 UC 14	1400	550	500	600
150 UC 23	8000	900	2500	700
150 UC 30	2000	900	1500	700
150 UC 37	1400	900	1200	700
200 UC 46	4000	900	3000	700
200 UC 52	3600	900	2500	700
200 UC 60	2500	1000	1500	700
250 UC 89	4000	1000	3000	700
310 UC 97	6000	1000	3000	850
310 UC 118	6000	1000	3000	850
310 UC 137	6000	1000	3000	850
310 UC 158	5100	1000	3000	850

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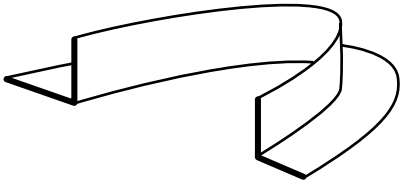
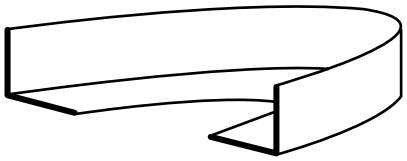
STEEL PROCESSING SERVICES

SECTION ROLLING

Channels I Beams I Columns I Angles I Pipe I RHS I Flat Bar

Angles

- Available rolled double toe in or out like a diamond.
- 150x90x8 - 90 toe in radius, 1525 inside
- 150x90x8 - 90 toe out radius, 832 inside
- 150x90x8 - 150 toe in radius, 3000 inside
- 150x90x8 - 150 toe out radius, 1000 inside
- 150x90x12 - 150 toe in radius, 1000 inside

TOE OUT	TOE IN
	

Section	Min. Radii	Lead In/Out	Min. Radii	Lead In/Out
25x25x3	150	200	300	200
50x50x6	250	300	350	300
75x75x6	450	400	500	350
100x100x6	1000	700	1500	700
100x100x10	450	700	650	700
125x125x6	1400	700	2000	700
125x125x12	700	700	900	700
150x150x12	900	750	1500	750
150x150x20	900	750	1000	750
200x200x13	3500	750	4500	750
200x200x20	2500	750	4000	750

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STEEL PROCESSING SERVICES

SECTION ROLLING

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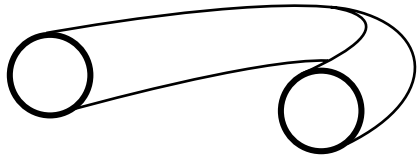
Pipe

- Cannot roll 457 pipe.

PIPE



Section	N.B	Min. Radii	Lead In/Out
21 OD x 2.6	15	150	200
27 OD x 2.6	20	150	200
34 OD x 3.2	25	200	200
42 OD x 3.2	32	200	200
48 OD x 3.2	40	200	300
60 OD x 3.6	50	250	350
76 OD x 3.6	65	350	350
89 OD x 4.0	80	550	600
102 OD x 4.0	90	450	600
114 OD x 4.5	100	600	600
140 OD x 4.9	125	850	700
168 OD x 6.4	150	1000	700
219 OD x 4.8	200	3000	700
219 OD x 6.4	200	1500	700
219 OD x 12.7	200	2000	700
273 OD x 6.4	250	2100	750
323 OD	300	CALL	CALL
356 OD	350	CALL	CALL
406 OD	400	CALL	CALL

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STEEL PROCESSING SERVICES

SECTION ROLLING

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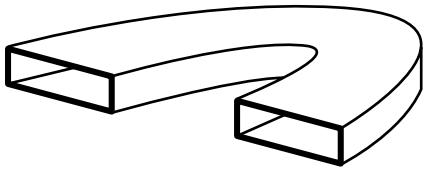
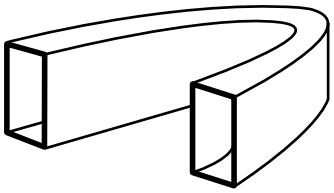
RHS

- Please call for larger section sizes.

	ON EDGE		BAND	
				
Section	**Min. Radii**	**Lead In/Out**	**Min. Radii**	**Lead In/Out**
25x25x3	150	300	-	-
40x40x2	2700	300	-	-
50x25x3	250	300	150	200
50x50x3	1200	-	-	-
50x50x4	350	350	-	-
75x50x5	500	450	350	350
75x75x3	3100	-	-	-
75x75x6	500	450	-	-
100x50x3	2500	500	3000	500
100x50x6	800	550	400	500
100x100x6	2500	600	-	-
100x100x9	1000	700	-	-
125x75x5	2500	700	1500	600
150x100x5	5000	-	-	-
150x100x6	2200	700	3000	700
150x150x6	5000	750	-	-
150x150x9	2000	750	-	-
200x100x6	10000	750	10000	800
200x100x9	3500	750	2000	750
200x150x9	7400	750	6000	750
200x200x9	9000	800	-	-
250x150x6	2100	-	-	-
250x150x9	7000	800	5000	800
250x250x9	17000	800	-	-
250x150x12.5	-	-	-	-

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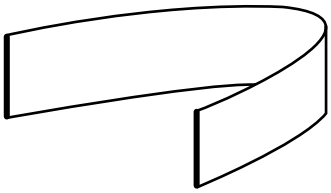
STEEL PROCESSING SERVICES

SECTION ROLLING

Channels I Beams I Columns I Angles I Pipe I RHS I Flat Bar

Flat Bar

- Also available rolled with a helix for spiral staircase stringers.

	ON EDGE		BAND	
				
Section	**Min. Radii**	**Lead In/Out**	**Min. Radii**	**Lead In/Out**
32x6	100	300	See plate capacity	-
50x6	200	300	See plate capacity	-
75x6	220	350	See plate capacity	-
75x20	400	350	See plate capacity	-
100x6	1000	450	See plate capacity	-
100x12	500	600	See plate capacity	-
100x25	500	600	See plate capacity	-
125x12	1000	600	See plate capacity	-
150x10	1200	600	See plate capacity	-
150x20	800	600	See plate capacity	-
200x12	1500	600	See plate capacity	-
200x25	700	700	See plate capacity	-
200x40	2200	700	See plate capacity	-
250x12	8000	700	See plate capacity	-
250x20	2000	700	See plate capacity	-
250x25	2000	750	See plate capacity	-
250x150	2700	750	CALL	CALL
400x30	4000	900	See plate capacity	-

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STEEL PROCESSING SERVICES

BRAKE PRESSING

With state-of-the-art technology, Rollco delivers repeatable accuracy and reliability in our brake pressing services, ensuring cost-effective solutions.

With cutting-edge equipment and expert craftsmanship, we deliver high-quality, bespoke steel components tailored to client needs. Our streamlined supply chain guarantees swift turnaround times, and we consistently meet our commitments.

Our comprehensive tooling inventory enables us to efficiently to accommodate a wide range of requirements, from straightforward bends to intricate shapes. This versatility accelerates setup and minimises adjustments, streamlining the bending process.

PROCESS

Press braking is a steel forming process used to accurately bend flat steel sheets or plates into precise angles and shapes. Steel press braking is widely used in industries like construction, manufacturing, automotive, heavy industry, and architecture.

CAPACITY

Our CNC machines boast a 550 tonne capacity, a six-metre bed, and a maximum capacity of 300 tonnes per metre. With a range of tooling options available, we can accommodate diverse project needs.

BRAKE PRESS CAPABILITY

The table below, based on 250-grade mild steel, showcases our capabilities and serves as a guide. Actual results may vary depending on the specific material and bend radii requirements.

Material Thickness	Min. Inside Radius	Min. Outside Leg	Plate Length					
			1000	2000	3000	4000	5000	6000
1.6mm	2.5	15						
3mm	3.2	17						
	5.7	25						
6mm	9.6	42						
8mm	9.6	49						
10mm	12.5	62						
	16.0	74						
12mm	12.5	66						
	16.5	78						
	22.0	98						
16mm	22.0	106						
20mm	35.0	170						
25mm	38.0	190						
	44.0	206						
	47.0	215						

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STEEL PROCESSING SERVICES

PLATE ROLLING

Rollco is an Australian leader in steel processing, specialising in cold roll bending and pressing of sectional and plate steel. We've serviced industrial customers since 1981 and are now part of the Southern Steel Group, Australia's largest independent steel supplier.

We're equipped with the industry's largest and most sophisticated machinery, managed by highly skilled and dedicated professionals. Our in-house capabilities streamline production, reducing the need for multiple orders and deliveries.

We're committed to meeting customer requirements and delivering exceptional quality, ensuring we stay at the forefront of industry demands.

PROCESS

Cold rolling is a globally recognised process for precision-shaping of steel flat plates into various radial forms such as cylinders, cones, arcs, or other curved components. It's widely used in industries like shipbuilding, pressure vessel fabrication, pipelines, construction, and heavy equipment manufacturing.

GREEN

The term 'green' describes the straight portions at the start and end of a curved piece, necessary for machine grip during rolling. With our double initial pinch machines, we can often pre-set the ends, reducing material costs and eliminating the need for additional cutting.

CAPACITY

Our range of machines, varying in size, can accommodate most project needs. The table below, based on 250-grade mild steel, serves as a general guide. For specific information on your project, please don't hesitate to contact us.

NOTES

230 plate rolls - 220mm minimum diameter, 2m long.

280 plate rolls - 350mm minimum diameter, 3m long, pending material thickness.

360 plate rolls - 460mm minimum diameter, 3.05m long, pending material thickness.long.

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STEEL PROCESSING SERVICES

PLATE ROLLING

ROLLING CAPACITY

The table below, based on 250-grade mild steel, showcases our capabilities. It serves as a guide and actual results may vary depending on the specific material and bend radii requirements.

LEGEND

Preset

Green Required

Thickness	Ø	Width									
		100	200	400	600	800	1000	1500	2000	2500	3000
1.6mm	250										
	400										
3mm	200										
	250										
	300										
	400										
6mm	200										
	250										
	400										
	500										
8mm	200										
	250										
	300										
	350										
	500										
10mm	200										
	250										
	300										
	500										
12mm	200										
	250										
	300										
	420										
	600										
16mm	400										
	500										
	800										
	1000										
20mm	400										
	600										
	800										
	1000										
	2000										
25mm	400										
	600										
	800										
	1000										
	2000										
	3000										
32mm	400										
	600										
	800										
	1000										
	2000										
	3000										
40mm	600										
	800										
	1000										
	2000										
	3000										
50mm	600										
	800										
	1000										
	2000										
	3000										

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STEEL PROCESSING SERVICES

GUILLOTINING

Since 1981, Rollco has been a trusted provider of high-quality curved steel and alloy products to the construction and manufacturing industries.

Our comprehensive services enable us to process most requirements in-house, minimising the need for multiple orders and deliveries.

We're dedicated to meeting customer specifications while delivering the highest standards of quality.

Rollco is committed to staying ahead of the curve, continually addressing customer and industry demands to ensure we remain the go-to supplier for quality curved steel and alloy products in Australia.

PROCESS

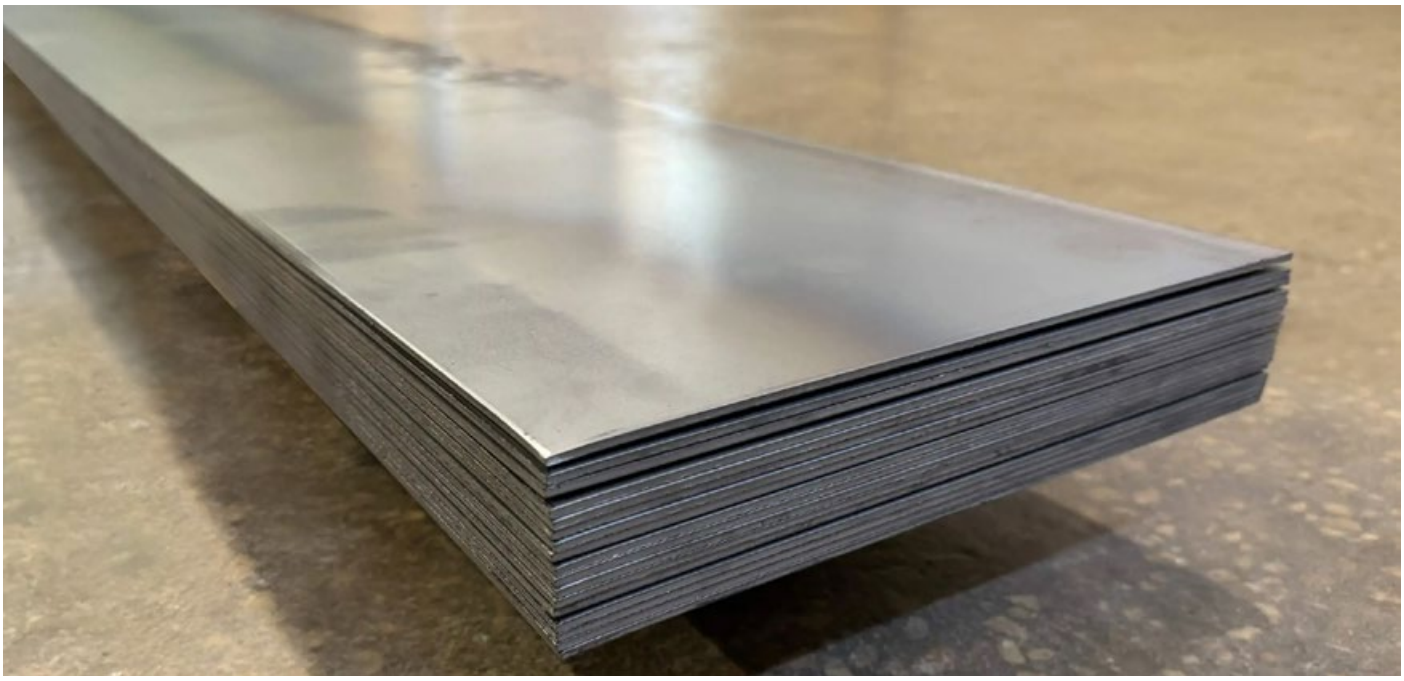
Guillotining, or shearing, are reliable methods for cutting steel sheets or plates in straight lines, minimising distortion issues often associated with other cutting techniques like profile cutting. This cutting method is particularly advantageous when further processing is needed, such as bending or rolling, as it doesn't introduce additional stresses into the material.

Steel guillotining is widely used wherever large sheets or plates of steel need to be cut into smaller, straight sections for construction, fabrication, shipbuilding, transport, and heavy equipment manufacturing.

CAPACITY

Rollco offers high-precision guillotining services for sheet and plate processing.

With the ability to process mild steel, stainless steel and aluminium, Rollco ensures every job is completed with consistency, efficiency and quality craftsmanship.



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STEEL PROCESSING SERVICES

PURLIN ROLLING

Rollco is well known for providing tailor-made steel solutions. With some of the largest and heavy-duty machinery in Australia, we can handle projects ranging from light sheet work to heavy structural beams.

Rollco also offers a flexible, one-stop service that adapts to unique project requirements. Our experienced team works closely with clients to deliver custom curved, bent, or pressed components that match exact specifications. This has enabled Rolco to supply specialised components for construction, infrastructure, mining, and piling industries.

Backed by quality systems and decades of experience, Rollco positions itself as a partner for customised, cost-effective, and reliable steel processing solutions.

PROCESS

Purlins are horizontal structural members in roof framing systems that support roof sheeting and transfer loads to the main frames. Our cold rolling process produces 'C' curved purlins, with curving limited to the X-X axis due to the section's thinness.

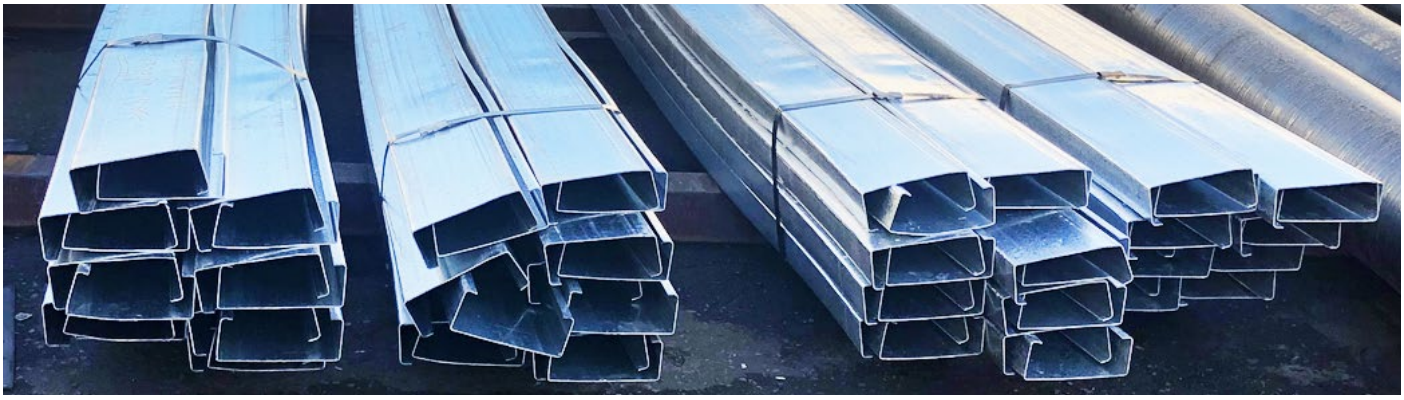
LEAD IN/OUT

Lead in/out refers to the straight material sections before and after the curved portion, necessary for machine grip during rolling. Due to purlin properties, twisting occurs during curving, so we require an additional 1100mm on each end for lead in/out to minimise this effect.

CAPACITY

As a general rule, specifying a heavier section allows for tighter radii and better section integrity.
The following table serves as a guide, but we recommend enquiring about specific details, as individual requirements may necessitate custom designs.

Section	Minimum Radius	Green Lead In/Out
C15024	8000mm	900 green each end
C20024	35000mm	900 green each end
C25024	75000mm	900 green each end
C10019	4500mm	600 green each end



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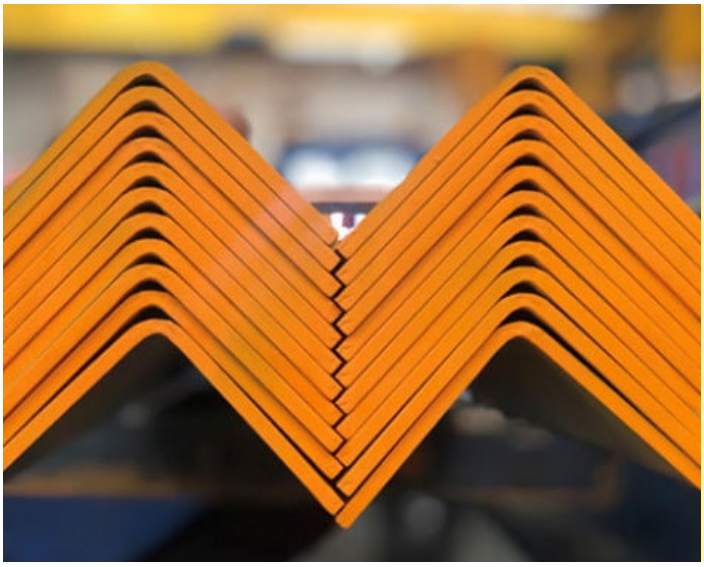
STEEL PROCESSING SERVICES

DURAGAL® PROCESSING

DuraGal® Angles I DuraGal® Channels

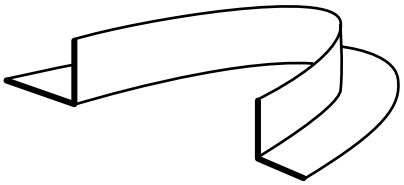


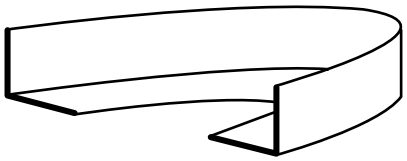
DuraGal® Profiles have a high level of corrosion resistance given the chemical composition of zinc with 3% magnesium content and 2.5% aluminium. The magnesium creates a stable and durable layer across the entire surface and gives a far more effective corrosion protection than coatings with a lower magnesium content.

The durability performance of DuraGal® is influenced by the micro-environments which vary from site to site. In highly corrosive environments, it is recommended that a suitable barrier coating, (e.g. paint or powder coating) be applied over the galvanised surface, and that the application of such coating be fully in accordance with the supplier's recommendations with regard to surface pre-treatment, application, curing and maintenance of the coating.

DuraGal® Angles

DuraGal® Angles are L-shaped galvanised steel sections designed for strong, corrosion-resistant, and versatile, structural use. Rollco processes DuraGal® Angles using advanced cold roll bending and pressing techniques to create custom-shaped steel components.





Section	TOE OUT		TOE IN	
	Min. Radii	Lead In/Out	Min. Radii	Lead In/Out
40x40x1.5	-	-	-	-
40x40x4.0	-	-	-	-
40x40x5.0	525 I/RAD	-	-	-
50x50x2.5	-	-	-	-
50x50x3.0	3000	-	-	-
50x50x5.0	350	300	500	300
50x50x6.0	-	-	500	400
65x65x4.0	-	-	-	-
65x65x5.0	-	-	-	-
65x65x6.0	-	-	-	-
75x75x4.0	-	-	-	-
75x75x6.0	1050	-	-	-
75x75x8.0	-	-	-	-
90x90x5.0	-	-	-	-
90x90x8.0	-	-	-	-
100x100x6.0	3000	450	-	-
100x100x8.0	750	500	3000	500
125x125x5.0	-	-	-	-
125x125x8.0	-	-	-	-
150x150x5.0	-	-	-	-
150x150x8.0	6000	600	6500	600

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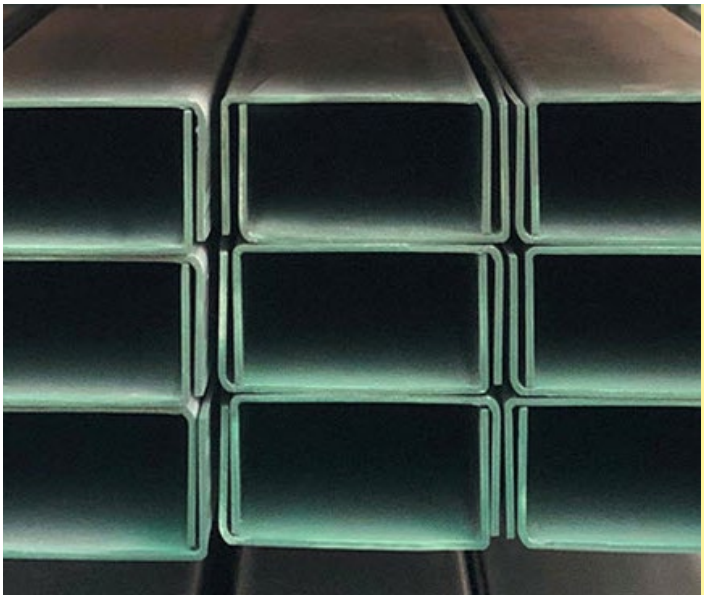
STEEL PROCESSING SERVICES

DURAGAL® PROCESSING

DuraGal® Angles I DuraGal® Channels



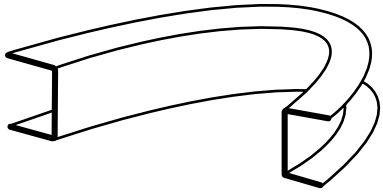
DuraGal® Profiles are a premium range of galvanised steel sections designed for enhanced corrosion resistance, durability, and ease of use.

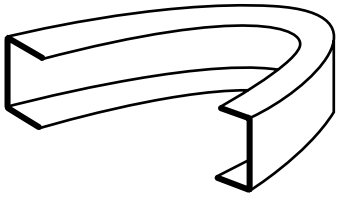
DuraGal® Profiles offer exceptional corrosion resistance due to their unique zinc coating, which contains 3% magnesium and 2.5% aluminium. The magnesium content creates a durable, stable layer that provides superior protection against corrosion.

The durability of DuraGal is affected by site-specific micro-environments. In highly corrosive settings, applying a protective barrier coating (such as paint or powder coating) over the galvanised surface is recommended. Ensure the coating is applied and maintained according to the supplier's guidelines.

DuraGal®Channels

DuraGal® Channels are C-shaped galvanised steel sections designed to provide strength, durability, and corrosion resistance. Rollco processes DuraGal® Channels using advanced cold roll bending and pressing techniques to create custom-shaped steel components.





Section	TOE OUT		TOE IN	
	Min. Radii	Lead In/Out	Min. Radii	Lead In/Out
75x40x4	-	-	-	-
100x50x4	1300	500	2000	500
125x65x4	-	-	-	-
150x75x5	2100	500	3000	500
180x75x5	-	-	-	-
200x75x5	2100	500	3500	500
200x75x6	-	-	-	-
230x75x6	-	-	-	-
250x90x6	3500	600	3700	600
300x90x6	4300	650	4500	650
300x90x7	-	-	-	-
300x90x8	-	-	-	-

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STEEL PROCESSING SERVICES

ADDITIONAL CAPABILITIES

Spiral Staircases

Rollco specialises in crafting spiral staircases using channels, pipes and flat bar stringers. With advanced in-house design software and powerful rolling equipment, we deliver smooth, accurate curves and durable, load-bearing performance, creating stair designs that are as functional as they are visually striking.

Axial Fan Cases

Rollco can manufacture high-quality axial fan cases using rolled and flanged steel techniques. We form cylindrical or conical shapes with advanced rolling and press brake machinery. Our techniques deliver strength, accuracy, and reliability in every component.

Flanges

Our team provides comprehensive flange processing solutions, expertly rolling flanges from steel angle or flat bar and flanging cylinder ends up to 45 degrees for mancoolers. With cutting-edge equipment and a highly skilled team, we produce engineered flanges tailored to project specifications.

Tunnel Sets

Rollco specialises in manufacturing complete steel tunnel sets, combining advanced rolling technology with expert processing techniques. Our comprehensive capabilities ensure that every component produces high-quality results for even the most complex tunnel construction projects.

Sheetmetal Work

Rollco excels in sheet metal processing, offering turnkey forming, shaping, and rolling solutions. With state-of-the-art technology and an experienced team, we deliver accurate, consistent, and high-quality results across various industrial and architectural applications.

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