AMERICAN PUNCH COMPANY

ISO CERTIFIED 9001:2008

High quality tooling and the best customer service in the business!

Typical Die Clearances for Punching Mild Steel

PUNCH SIZE	MATERIAL THICKNESS (DIE SIZES) 1/8	1/4	3/8	1/2	5/8	3/4
3/16	13/64					
1/4	17/64					
5/16	21/64	11/32				
3/8	25/64	13/32				
7/16	29/64	15/32	15/32			
1/2	33/64	17/32	17/32			
9/16	37/64	19/32	19/32	5/8		
5/8	41/64	21/32	21/32	11/16		
11/16	45/64	23/32	23/32	3/4	3/4	
3/4	49/64	25/32	25/32	13/16	13/16	
13/16	53/64	27/32	27/32	7/8	7/8	29/32
7/8	57/64	29/32	29/32	15/16	15/16	31/31
15/16	61/64	31/32	31/32	1	1	1-1/32
1	1-1/64	1-1/32	1-1/32	1-1/16	1-1/16	1-3/32
1-1/16	1-5/64	1-3/32	1-3/32	1-1/8	1-1/8	1-5/32
1-1/8	1-9/64	1-5/32	1-5/32	1-3/16	1-3/16	1-7/32
1-3/16	1-13/64	1-7/32	1-7/32	1-1/4	1-1/4	1-9/32
1-1/4	1-17/64	1-9/32	1-9/32	1-5/16	1-5/16	1-11/32
1-5/16	1-21/64	1-11/32	1-11/32	1-3/8	1-3/8	1-13/32
1-3/8	1-25/64	1-13/32	1-13/32	1-7/16	1-7/16	1-15/32
1-7/16	1-29/64	1-15/32	1-15/32	1-1/2	1-1/2	1-17/32
1-1/2	1-33/64	1-17/32	1-17/32	1-9/16	1-9/16	1-19/32

This chart is for reference only. Check with machine manufacturer for specific applications.

Required Tonnage for Punching Mild Steel with Tensile Strength of 50,000 PSI

MATERIAL THICKNESS		PUNCH SIZE 3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1-1/8	1-1/4
3/16	.187	3	4	5	6	7	8	9	9	10	11	12	13	14	15	17	19
1/4	.250		5	6	8	9	10	11	13	14	15	16	18	19	20	23	25
3/8	.375				11	13	15	17	19	21	23	24	26	28	30	33	38
1/2	.500						20	23	25	28	30	33	35	38	40	45	50
5/8	.625								31	34	38	41	44	47	50	56	63
3/4	.750										45	49	53	56	60	68	75
7/8	.875												61	66	70	78	88
1	1.000														80	90	100

REQUIRED TONNAGE

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