

Round or Square Die Clearance Guide:

The following guide can be used when punching mild steel

Material Thickness	mm	Up to 4	4 – 9.5	10 – 14.5	15 – 19.5	20 - 24
Die Clearance	mm	0.2	0.7	1.2	1.7	2.2

Note: When you have determined the “Die Clearance” you require, you will need to add this amount to the punch size you are using: Refer examples below

Example 1:	Punch Round	Ø18mm
	Material Thickness	12mm
	Die Clearance	1.2mm
	Ø18mm + 1.2mm =	19.2mm
	Die Required	Ø19.2mm

Example 2:	Punch Square	18x18mm
	Material Thickness	9mm
	Die Clearance	0.7mm
	18x18mm + 0.7mm =	18.7mm
	Die Required	18.7 x 18.7mm