



PUNCH & DIE CLEARANCE

COLD ROLLED STEEL | ALL DIMENSIONS IN INCHES

TOTAL CLEARANCE = DIE OPENING MINUS PUNCH SIZE

US gauge / fraction	Nominal thickness	15%	20%	25%	30%	Recommended total clearance*
25	.021	.003	.004	.005	.006	.006
24	.024	.004	.005	.006	.007	.006
22	.030	.005	.006	.008	.009	.006
20	.036	.005	.007	.009	.011	.006
19	.042	.006	.008	.011	.013	.006
18	.048	.007	.010	.012	.014	.012
16	.060	.009	.012	.015	.018	.012
14	.075	.011	.015	.019	.023	.018
13	.090	.014	.018	.023	.027	.018
12	.104	.016	.021	.026	.031	.024
11	.120	.018	.024	.030	.036	.024
10	.134	.020	.027	.034	.040	.030
9	.150	.023	.030	.038	.045	.030
7	.179	.027	.036	.045	.054	.045
3/16	.187	.028	.037	.047	.056	.045
7/32	.219	.033	.044	.055	.066	.055
1/4	.250	.038	.050	.063	.075	.055
3/8	.375	.056	.075	.094	.113	.094

HOW TO USE

Find your thickness, then read the recommended total clearance at right.

Example: .500 punch + .012 total clearance = .512 die opening.

Clearance per side is half the total: .012 total = .006 per side.

*Recommended values reproduce the supplied shop chart; they are not universal settings. Nominal thicknesses follow that chart and are rounded. Measure the stock; confirm material, tooling and press capacity before use. Percentage columns are calculated from the listed thickness and rounded to .001 inch.