

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