

| Punch & Die CLEARANCES | |
|--------------------------------------|-----------------------------------|
| Material Thickness | Die Clearance - ADD to Punch Size |
| 30 ga. (.0120") - 26 ga. (.0179") | Slip Fit |
| 25 ga. (.0209") - 23 ga. (.0269") | .002" |
| 22 ga. (.0299") - 19 ga. (.0418") | .003" |
| 18 ga. (.0478") - 16 ga. (.0598") | .005" |
| 15 ga. (.0673") - 14 ga. (.0747") | .007" |
| 13 ga. (.0897") - 11 ga. (.1196") | .010" |
| 10 ga. (.1345") - 7 ga. (.1793") | 1/64" |
| 1/4" up to 1/2" Plate | 1/32" |
| 1/2" up to 1" Plate | 1/16" |
| 1" up to 1-1/2" Plate | 3/32" |