



6087 NETHERHART ROAD, UNIT 4,  
 MISSISSAUGA, ON. L5T 1G5  
 Phone (905) 670-2975 Fax (905) 670-5738

“The Name Says it All”

## Hole Punching Capacities

Milder Steel	30 TON	50 TON
Max. Thickness	Max. Hole Dia.	Max. Hole Dia.
14 ga. .074 in. (1.9mm)	3-1/2 in. (90.0mm)	5 in. (127.0mm)
12 ga. .104 in. (2.6mm)	3-1/2 in. (90.0mm)	5 in. (127.0mm)
11 ga. .199 in. (3.0mm)	3-1/4 in. (79.4mm)	5 in. (127.0mm)
10 ga .134 in. (3.4mm)	2-13/16 in. (71.5mm)	4-5/8 in. (117.5mm)
5/32 in. .156 in. (4.0mm)	2-3/8 in. (60.3mm)	4 in. (101.6mm)
3/16 in .187 in. (4.8mm)	2 in. (50mm)	3-3/8 in. (85.7mm)
1/4 in. .250 in. (6.4mm)	1-1/2 in. (38.1mm)	2-1/2 in. (63.5mm)
3/8 in. .375 in. (9.5mm)		1-11/16 in. (42.8mm)

Above capacities based on 50,000 psi mild steel with no shear on punches and dies.

To obtain tonnage required for punching round holes in mild steel --- multiply as follows:

$$\text{Diameter of Hole} \times 3.14 \times \text{Material Thickness} \times 25 =$$

Punching Pressure Require for One Hole

To obtain tonnage required for Rectangular holes in mild steel - Multiply  
 Perimeter X Material Thickness X 25



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1/64 -----01562	33/64 -----5156
1/32 -----03125	17/32 -----5312
3/64 -----04687	35/64 -----5468
1/16 -----0625	9/16 -----5625
5/64 -----07812	37/64 -----5781
3/32 -----09375	19/32 -----5937
7/64 -----10937	39/64 -----6093
1/8 -----125	5/8 -----625
9/64 -----14062	41/64 -----06406
5/32 -----1562	21/32 -----6562
11/64 -----1718	43/64 -----6718
3/16 -----1875	11/16 -----6875
13/64 -----2031	45/64 -----7031
7/32 -----2187	23/32 -----7187
15/64 -----2343	47/64 -----7343
1/4 -----250	3/4 -----750
17/64 -----2656	49/64 -----7656
9/32 -----2812	25/32 -----7812
19/64 -----2968	51/64 -----7968
5/16 -----3125	13/16 -----8125
21/64 -----3281	53/64 -----8281
11/32 -----3437	27/32 -----8437
23/64 -----3593	55/64 -----8593
3/8 -----375	7/8 -----875
25/64 -----3906	57/64 -----8906
13/32 -----4062	29/32 -----9062
27/64 -----4218	59/64 -----9218
7/16 -----4375	15/16 -----9375
29/64 -----4531	61/64 -----9531
15/32 -----4687	31/32 -----9687
31/64 -----4843	63/64 -----9843
1/2 -----500	1 -----1.000

#### RECOMMENDED CLEARANCE FOR STEEL

GAUGE	CLEARANCES	U.S. STD.
20	.009	.0359
19	.009	.0418
18	.009	.0478
17	.012	.0538
16	.012	.0598
15	.015	.067
14	.018	.0747
13	.021	.0897
12	.021	.1046
11	.024	.1196
10	.024	.1345
9	.030	.1495
8	.030	.164
7	.035	.179
6	.035	.194
5	.040	.209
1/4	.050	.250