

Technical Resources from Trick-Tools.com

Tons of Pressure Required to Shear 1" Length

Metal Gauge	Mild Steel	Stainless Steel	Brass
20	1.01	1.50	.75
18	1.25	1.75	1.00
16	1.75	2.50	1.25
13	2.50	3.50	2.00
11	3.25	4.75	2.25
3/16"	4.25	7.00	3.25
1/4"	6.25	9.50	4.50
5/16"	8.00	12.00	5.50
3/8"	9.50	14.25	6.25
7/16"	11.00	16.50	7.75
1/2"	12.50	18.75	8.75
5/8"	15.75	23.50	11.00
3/4"	18.75	28.25	13.25
7/8"	22.00	33.00	15.50
1"	25.00	37.50	17.50

Clearances for Mild Steel

Gauge or Size	Approx. Decimal Thickness	Overall Clearance - Add To Punch Size
30	.0120	Slip Fit
28	.0149	Slip Fit
26	.0179	
24	.0239	.003
22	.0299	.003
20	.0359	.004
18	.0478	.005
16	.0598	.005
14	.0747	.006
13	.0897	.009
12	.1046	.009
11	.1196	.011
1/8	.125	.011
10	.1345	.013
5/32	.156	.015
8	.164	.017
7	.1793	.021
3/16	.1875	.023
1/4	.250	.037
5/16	.3125	.047
3/8	.375	.057
1/2	.500	.075
5/8	.625	.125
3/4	.750	.150