

DETERMINING DIE CLEARANCE

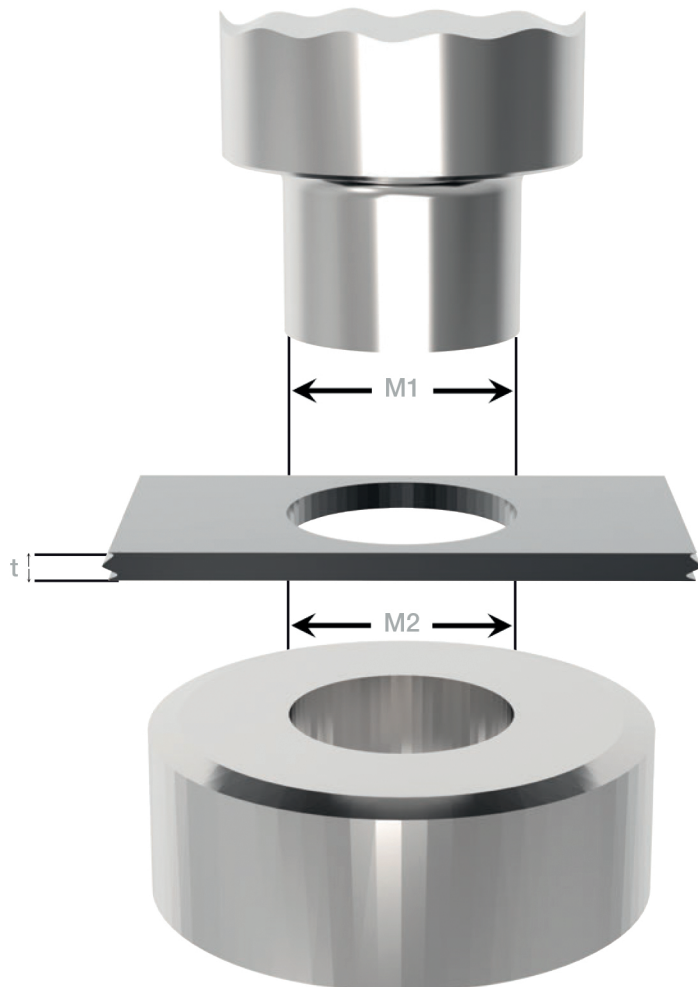
Formula for calculating the right die measure:

$$M2 = M1 + f \times t_{\text{sheet thickness}}$$

M1 = punch measure

M2 = die measure

f = multiplier



f = multiplier for sheet type

Spring steel:	f = 0,30 mm
Stainless steel (e.g. 1.4301):	≤ 2 mm (f = 0,2) > 2 mm (f = 0,25)
Steel (e.g. DC01):	f = 0,20 mm
Aluminium:	f = 0,15 mm