

We make it  
**EASY  
TO ORDER**

**O**ur goal has always been to get you the right tooling, at the right time, at the right price. For us to do that, we need some important information from you, our customer:



**1**

### QUANTITY

We need to know the quantity of tooling you are ordering since we offer price breaks on most items when ordering the same size.

**2**

### SIZE

Most of our customers know the size of the punch that they want to order. The die size is then usually determined by the thickness of the material being punched. If a punch and die are ordered without the proper clearance, reduced tool life, choppy hole finish, or a heavy burring can occur. If no die clearance is specified, we will provide 1/32 clearance as standard.

**STANDARD CLEARANCE  
RECOMMENDED  
BETWEEN PUNCH AND DIE  
WHEN PUNCHING STEEL**

Standard die size is punch size plus 1/32" or 1/16"

**For 3/16 - 1/2" material thickness, allow 1/32" total clearance**

**For 1/2 - 3/4" material thickness, allow 1/16" total clearance**

**Over 3/4" material thickness, allow 3/32" total clearance**

**3**

### SHAPE

Need round, oblong, square, rectangular or hexagonal shaped tooling? No problem! See page 10 of our catalog for all of the standard shapes.

**4**

### TOOLING PART NUMBER

If you have existing tooling, there will be a part number on it for you to reference when ordering. If you have the make and model of your machine, you can always visit our website to use the "Search for Tooling" button to find your tooling part number. **If you don't have the part number or don't know the name of the ironworker see reverse side for punch and die dimension worksheet.**

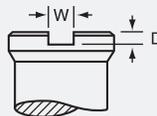
**5**

### KEYWAYS AND WHISTLE SPOTS

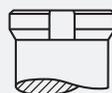
Keyways are used on shaped punches only and are necessary to properly align the tooling and to keep the punch from turning if it becomes loose. There is usually one or two keyways required, depending on the machine, although some machines don't use them at all. If the stem on your machine has one keyway, two are required on the punch. If the stem on the machine has two keyways, you really need only one on the punch. There can be up to seven different types of keyways for the punch, usually determined by the machine make and model. If you don't know the machine make and model, we'll need to know the keyway width and depth. Two whistle spots are typically provided on the dies.



"V" Groove  
Round Key  
Stock



Standard  
Square Key  
Stock



Side Head  
Square Key  
Stock



Standard Keyway Position

**AMERICAN PUNCH**  
COMPANY

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