



	Hole	<p>Minimum diameter is T or .040" whichever is greater. Distance to a bend is 3T plus bend radius minimum. Allow up 20% increase in diameter on punch exit side.</p>
	Bend	<p>Angles $\pm 1^\circ$ Minimum BR is T and is greater for less ductile materials. Shortest flange length is .125" for T < .036" and 3.25T for T = .036" or greater (without custom dies and deep tooling marks).</p>
	Tolerance For Distance	<p>Over 2 Bends (2B) $\pm .020''$ Hole to Hole (H2H) $\pm .005''$ Hole to Hole Over 2 Bends (H2H/2B) $\pm .020''$ Hole to Bend (H2B) $\pm .015''$ Hole to Edge (H2E) $\pm .010''$ Edge to Edge (E2E) $\pm .020''$ (Constrained) Hole to Hole Over 4 Bends (H2H/4B) $\pm .020''$ (Constrained) Edge to Bend (E2B) $\pm .015''$</p>
	Coiled Counter Bore	<p>Distance between counter bores is 8T minimum. Distance to edge is 4T minimum. Distance to bend is 4T plus BR minimum.</p>
	Coiled Counter Sink	<p>Distance between counter sinks is 8T minimum. Distance to edge is 4T minimum. Distance to bend is 4T plus BR minimum.</p>
	Hem	<p>Tear drop or open hem design for products to be plated. Opening is .25T or .010" whichever is greater. Return flange length is 4T minimum.</p>
	Curl	<p>Radius is 2T with a minimum inside diameter of T. Distance to edge is radius plus T minimum. Distance to other features is 6T plus curl radius minimum.</p>
	Dimple	<p>Diameter of 6T and depth of $\frac{1}{2}$ the small diameter maximum. Distance to bend, to hole, to edge, and another dimple is 2T, 3T, 4T, and 4T respectively, plus the radius of the small diameter.</p>
	Extruded Hole	<p>Distance between extruded holes is 6T minimum. Distance to edge is 3T minimum. Distance to bend is 3T plus the BR minimum.</p>
	Gusset	<p>Width and depth is proportional to the radius and T. Recommended angle of 45° Distance from edge of hole is 8T plus the radius of the gusset.</p>
	Emboss	<p>Maximum depth is proportional to the small radius or T. Depth for flat emboss is the small radius plus the large radius maximum and for 'V' emboss is 3T maximum.</p>
	Lance (Bridge)	<p>(Open) Width is greater of 2T or .06" and length is 5T maximum. (Closed) Width is greater of 2T or .125" and height is 5T max. Distance to edge of hole is 3T and to bend is 8T.</p>
	Rib	<p>Maximum inside radius is 3T and depth is inside radius. Minimum distance from center of rib to edge of hole is 3T, to edge is 8T, and to bend 2T plus BR, and plus inside radius of rib.</p>
	Half-Shear	<p>Distance half-shear to half-shear is 8T minimum. Distance to other form is 3T plus form radius. Distance to bend is 2T plus BR.</p>