

## Punching / Perforating KYDEX® Thermoplastic Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

### TB - 129

#### I. Punching KYDEX® Sheet

KYDEX® sheet may be cut by punching or stamping with sheet metal punches and punching equipment. Arch or gasket punches may also be used. These punches have a zero shearing angle, so considerable force is necessary to make the cut.

Please note that the cutting forces will be somewhat lower for punches that have a shearing angle. Also note that KYDEX® sheet of 6.35mm (0.250") or greater thickness must be punched with power operated equipment.

KYDEX® sheet punches cleanly with no chipping or cracking. In some cases, however, there may be some stresswhitening at the entry hole. This may be removed by gently heating the affected area with a flameless source of heat. Care must be taken to avoid causing localized distortions in the KYDEX® sheet.

Relatively small parts of thin gauge KYDEX® sheet can be stamped with sheet metal punch and die sets. Punching, stamping, and shearing may sometimes be combined with other fabrication methods such as brake forming to produce parts of complex shape cut to finished dimensions in a single operation.

Thickness	Punching Force, lbs/linear inches of cut
0.71mm (0.028")	150
1.02mm (0.040")	250
1.52mm (0.060")	500
2.03mm (0.080")	700
2.36mm (0.093")	1000
3.18mm (0.125")	1350

#### KYDEX, LLC

ISO 9001 and 14001 Certified

#### Customer Service

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 Fax: 800.452.0155, +1.570.387.7786  
 Email: info@kydex.com

#### Technical Service

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[www.kydex.com](http://www.kydex.com)

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#### II. Perforating KYDEX® Sheet

KYDEX® sheet is ideally suited for perforation applications. It is lighter and more corrosive resistant than metal and retains all physical, chemical, color and thermoforming properties before, during and after perforation.

The following companies are familiar with the perforation of KYDEX® sheet products in a variety of patterns, and can be contacted for information.

#### Diamond Perforated Metals, Inc.

300 West Sunnyview Ave  
Visalia, CA 93291  
800.642.4334  
(Micro-perforated available as pattern #5555)

#### Quality Perforating, Inc

166 Dundaff Street  
Carbondale, PA 18407  
800.872.7373

#### Diamond Manufacturing Company

243 West 8th Street  
Wyoming, PA 18644

2001 Grays Road  
Baltimore, MD 21222

600 Royal Road  
Michigan City, IN 46360

800.233.9601  
perf@dmc.microserve.com  
www.diamondman.com

#### Ametco, Inc

4326 Hamann Parkway  
PO Box 1210  
Willoughby, OH 44096  
440.951.4300  
www.ametco.com

#### Erdle Perforating Company

100 Pixley Industrial Parkway  
Rochester NY 14603  
585-247-4700  
www.erdle.com

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This information supersedes all previously published data.