

Punching / Perforating KYDEX® Thermoplastic Sheet

INTRODUCTION

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 stress whitening 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



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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.

7300 West Sunnyview Ave
Visalia, CA 93291
800.642.4334
(Micro-perforated available as pattern #5555)
www.diamondperf.com

Quality Perforating, Inc

166 Dundaff Street
Carbondale, PA 18407
800.872.7373
www.qualityperf.com

Diamond Manufacturing Company

243 West 8th Street
Wyoming, PA 18644
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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Because we cannot anticipate or control the many different conditions under which this information and our products may be used, we do not guarantee the applicability of the accuracy of this information or the suitability of our products in any given situation. Users should conduct their own tests to determine the suitability of each product for their particular purposes. Data in the physical property table represents typical values and are to serve only as a guide for engineering design. Results are obtained from specimens under ideal laboratory conditions. Right to change physical properties as a result of technical progress is reserved. THE PRODUCTS DISCUSSED ARE SOLD WITHOUT WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE, EITHER EXPRESSED OR IMPLIED, EXCEPT AS PROVIDED IN OUR STANDARD TERMS AND CONDITIONS OF SALE. Buyer assumes all responsibility for loss or damage arising from the handling and use of our products, whether done in accordance with directions or not. In no event shall the supplier or the manufacturer be liable for incidental or consequential damages. Also, statements concerning the possible use of our products are not intended as recommendations to use our products in the infringement of any patent. Consult local code and regulatory agencies for specific requirements regarding code compliance, transporting, processing, recycling and disposal of our product. Product not intended for use as a heat resistant surface. Texture, product grade and other conditions may cause variations in appearance.

This information supersedes all previously published data.