

Punching / Perforating KYDEX® Thermoplastic Sheet

TB - 153-B

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 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

SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

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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.