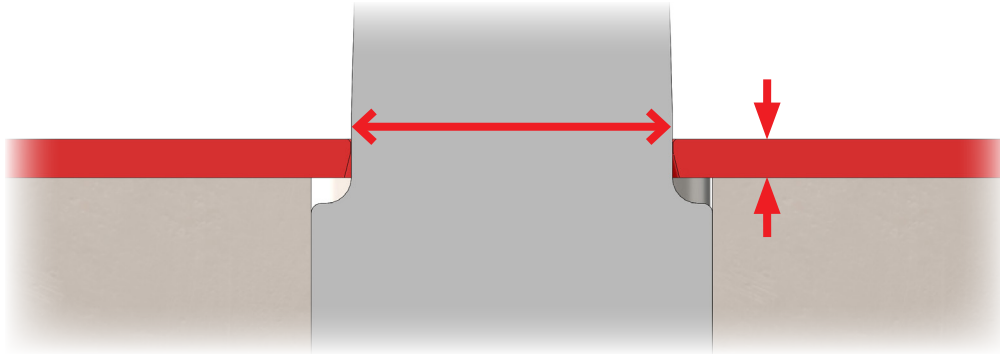


Usage Guidelines & Recommendations

Max Stock Thickness to Tapered Pilot Diameter



Pilot Diameter	Max Recommended Stock Thickness
10mm / .375"	1.9mm / .075"
13mm / .500"	2.5mm / .100"
16mm / .625"	3.2mm / .125"
20mm / .75"	3.8mm / .150"

The above maximum stock thickness is a recommendation based on typical die conditions.



“Receiving Hole” Clearance

Clearance minimizes the forces subjected on the Pilot and tooling during a miss-hit situation. The hole above the pilot allows the material to extrude, rather than creating a “pinch trim” situation. We recommend the clearance per side is equal to the stock thickness. This allows for adequate clearance during a mis-hit while still supporting the stock during normal running conditions.

Clearance Hole Diameter Formula:
Pilot Diameter + (Stock Thickness x 2)

