

Cutting clearance in percentages of material thickness per side

TABLE 6-3 Cutting Clearances in Percentages of Material Thickness Per Side

All materials, up to 0.001 in. (0.03 mm) thickness	0.0001 in. per side 0.003 mm per side
All materials, 0.001–0.025 in. (0.03–0.65 mm) thickness	5% per side
Blue steel, up to 0.025 in. (0.65 mm) thickness	
Copper, brass, soft steel, 0.025 in. (0.65 mm) thick and up	5–8% per side 5% per side, ID
Medium hard steel, 0.025 in. (0.65 mm) thick and up	8% per side, OD 6% per side, ID
Stainless steel, carbon steel, Cr-Ni steel, 0.025 in. (0.65 mm) thick and up	9% per side, OD 8% per side, ID 10% per side, OD

Note: Clearances for aluminum to be used according to its comparable hardness.

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