

Scrap allowance for blanking

Material	When length of skeleton segment between blanks or along edge is equal to or less than $2t$			When length of skeleton segment between blanks or along edge is equal to or greater than $2t$		
	Thickness of stock, t	Edge of stock to blank	Between blanks, same row	Thickness of stock, t	Edge of stock to blank	Between blanks, same row
Metals, general: Standard strip stock	Under 0.021 in. (0.5 mm)	0.050 in. (1.3 mm)	0.050 in. (1.3 mm)	Under 0.044 in. (1.1 mm)	0.050 in. (1.3 mm)	0.050 in. (1.3 mm)
	0.022–0.055 in. (0.5–1.5 mm)	0.040 in. (1.0 mm)	0.040 in. (1.0 mm)	Above 0.044 in. (1.1 mm)	0.9 t	0.9 t
Extra-wide stock and weak scrap skeleton	Under 0.042 in. (1.1 mm)	0.060 in. (1.5 mm)	0.050 in. (1.3 mm)	Under 0.033 in. (0.85 mm)	0.060 in. (1.5 mm)	0.050 in. (1.3 mm)
	Above 0.042 in. (1.1 mm)	1.4 t	1.2 t	Above 0.033 in. (0.85 mm)	1.8 t	1.6 t
Stock run through twice	Under 0.042 in. (1.1 mm)	0.060 in. (1.5 mm)	0.050 in. (1.3 mm) [†]	Under 0.033 in. (0.85 mm)	0.060 in. (1.5 mm)	0.050 in. (1.3 mm) [†]
	0.043–0.055 in. (1.1–1.5 mm)	1.4 t	0.040 in. (1.0 mm)	0.034–0.044 in. (0.85–1.1 mm)	1.8 t	0.040 in. (1.0 mm)
Stock run through twice and first and second row of blanks interlock	Above 0.055 (1.5 mm)	1.4 t	0.7 t	Above 0.044 in. (1.1 mm)	1.8 t	0.9 t
	Under 0.042 in. (1.1 mm)	0.060 in. (1.5 mm)	0.050 in. (1.3 mm) [*]	Under 0.033 in. (0.85 mm)	0.060 in. (1.5 mm)	0.050 in. (1.3 mm) [*]
Steel (silicon, spring, stainless)	Above 0.042 in. (1.1 mm)	1.4 t	1.4 t [†]	Above 0.033 in. (0.85 mm)	1.8 t	1.8 t [†]
	Under 0.042 in. (1.1 mm)	0.060 in. (1.5 mm) min.	0.060 in. (1.5 mm) min.	Under 0.033 in. (0.85 mm)	0.060 in. (1.5 mm) min.	0.060 in. (1.5 mm) min.
	Above 0.042 in. (1.1 mm)	1.4 t	1.4 t	Above 0.033 in. (0.85 mm)	1.8 t	1.8 t

^{*}Allow 0.060 in. (1.5 mm) between blanks at first and second rows.

[†]Allowance between blanks in the same row and also between blanks of first and second rows.

(C)