

ICS 25.020
CCS J32



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 16743-2010

Replacing GB/T 16743-1997

Blanking clearance

冲裁间隙

Issued on: September 26, 2010

Implemented on: February 1, 2011

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

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Foreword

This standard replaces GB/T 16743-1997 "blanking gap." This standard compared with GB/T 16743-1997, the main changes are as follows:

- Punched categories were further subdivided to relax the blanking interval selection value;
- Specifies the range used in the production of blanking clearance;
- Increasing the selection principle of blanking clearance when EDM mold edge;
- Information about double clad sheet metal punching gap material selection principles;
- Remove the hot-rolled silicon steel grades have been eliminated;
- Increased references;
- On the part of the text made editorial changes. This standard by the National Standardization Technical Committee Forging (SAC/TC74) and focal points. This standard was drafted. Xi'an Jiaotong University. The main drafters of this standard. Guo, Wu Huaying, Stone only. This standard replaces the standards previously issued as follows:
 - GB/T 16743-1997. Blanking Clearance

1 Scope

GB/T 16743-2010 is the Chinese national standard on blanking clearance, in the field of manufacturing engineering. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 26 September 2010 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 February 2011. Classification: ICS 25.020, CCS J32. This

page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This standard specifies the blanking clearance value of sheet metal and nonmetal board materials, as well as when using the gap value can reach the size of the blanking member Precision and cut surface quality. This standard applies to a thickness of 10mm or less metal and nonmetal materials conventional blanking plate.

2 Definitions, symbols Definition and standard symbols used blanking interval as shown in Table 1 and Table

2 Table 1 defines definition The distance blanking mold die and the punch blade between the side walls. 1- sheet; 2- punch; die 3- Blanking Die schematic Table

2 Symbol symbol Symbol Name Unit Legend Legend c blanking clearance (unilateral gap) to material thickness percentage /% t t sheet thickness mm tau material shear strength MPa R droop height of the thickness of the material expressed as a percentage /% t B bright band height to thickness of the material expressed as a percentage /% t F fault height thickness of the material expressed as a percentage /% t Fracture angle alpha (°) h burr height mm f Flatness mm

3 blanking clearance

3.1 Sheet Metal Blanking Clearance

3.1.1 Classification blanking clearance The main factor in the dimension accuracy by punching shear surface quality, tool life and force and energy consumption, the sheet metal punching into the gap in Table

3 Shown in five categories, namely. i class (small gap), ii class (small gap), iii class (middle gap), iv class (large gap) and v class (large gap).