

Design Guidelines For Cut Features

Distance Between Features

A minimum distance between features should be maintained to ensure the integrity of the cut. Following the guidelines below will ensure reliable results no matter the sheet cutting method.

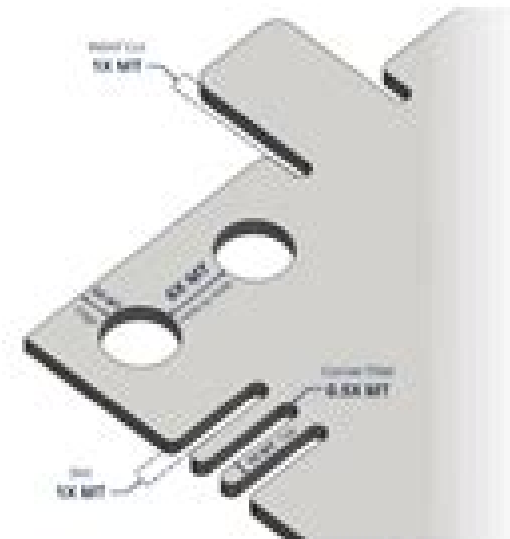
MT = Material Thickness

- Minimum Hole to Edge Distance = $2X$ MT or 3 mm, whichever is smaller
- Minimum Hole to Hole Distance = $6X$ MT or 3 mm, whichever is smaller
- Minimum Relief Cuts = 0.25 mm or $1X$ MT, whichever is greater
- Minimum Corner Fillets = $0.5X$ MT or 3 mm, whichever is smaller
- Minimum Tab Thickness = 1.6 mm or $1X$ MT, whichever is greater
- Minimum Slot Thickness = 1 mm or $1X$ MT, whichever is greater

Minimum Detail Sizes

Before a feature is cut, the tool (e.g. laser beam, waterjet stream, etc.) must pierce through the material at the start point of the cut. Holes and other internal shapes should be sized appropriately to allow for this action.

A good rule of thumb is to design your details to be at least 50% of the material's thickness or larger. Also, remember to account for kerf width, as features that are designed below the kerf width will become blown out or lost.



- ✓ - Larger than 50% Material Thickness
- ✗ - Less than 50% Material Thickness



Design Guides For Sheet Metal Fabrication

WJ Hussar



Design Guides For Sheet Metal Fabrication:

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