

Roll-Forming Services — Punching, Notching & Pre-Piercing

In-line and secondary operations on roll-formed sections

A roll-formed section usually leaves the line needing holes, slots or cut-outs. This sheet sets out what can be done in line, what is done as a second operation, and what has to be defined before a quotation is meaningful.

Operations

Operation	Where it is done	Notes
Punching / pre-piercing	In line, on the fly or stationary	Cheapest when the pattern repeats and the tooling is dedicated
Slots and elongated holes	In line	Used where a connection needs adjustment on site
Notching and end cuts	In line or secondary	End details for lapping and connections
Cut to length	In line	Length tolerance must be stated on the enquiry
Bending / press brake work	Secondary	For items the roll former cannot form

What to define on the enquiry

Section and material	Drawing or designation, steel grade and coating — steel properties set the maximum thickness
Hole pattern	Positions, diameters, tolerances and whether the pattern repeats at a fixed pitch
Tolerance class	Hole position and length tolerances, to the tolerance standard your project uses
Quantities	Total metres plus the smallest order the tooling can be justified at
Tooling	Whether the punching tooling is dedicated to the job, which is what drives the set-up cost

Standards referenced

EN 10162 (cold rolled steel sections — delivery conditions and tolerances) · EN 10346 / AS 1397 (coated steel) · EN 1993-1-3 and AISI S100 for the member design, because punching and notching reduce the effective section · customer drawing governs the hole pattern

Need a quote? Send the section drawing with the hole pattern, material, tolerances and quantities.

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