Claims:

1. A punch having a center and comprising a drive surface, said drive surface extending from an inner to an outer diameter formed of polygon involutes comprising a plurality of continuous tangent arcs, wherein each arc has a radius within the punch, wherein each arc is convex relative to the center of the punch, wherein each radius is constant but different, and wherein each radius has a center located on locus points of a radius at the center of the punch.

2. A punch as recited in claim 1, wherein the punch comprises a plurality of flutes, each flute comprising surfaces which are formed of polygon involutes.

3. A punch as recited in claim 1, wherein the punch comprises a plurality of flutes, each flute comprising surfaces which are formed of polygon involutes comprised of two arcs.

4. A punch as recited in claim 1, wherein each arc has a different radius, and each arc has a constant radius, wherein each is a segment of a circle.

5. A punch as recited in claim 1, further comprising a wall between each flute, said wall being flat, concave circular, convex vertex or concave vertex.