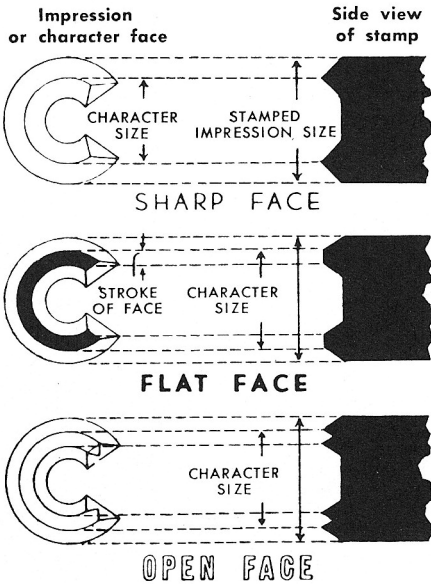


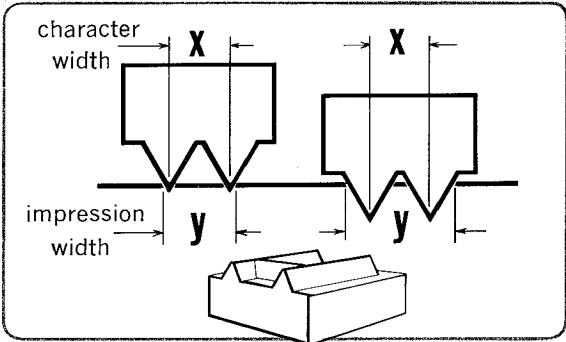
Standard Marking Data

Determining Character Size

The graphic below simplifies ordering the correct character size. If in doubt, send an impression for accurate identification.



Character size is measured at the face, or the sharp cutting edge of the character. *Impression* size will vary according to the depth of penetration.



CONDENSED



* REGULAR



* EXTENDED



*CAUTION: "Extended" is same size as "STANDARD" of some other makers.

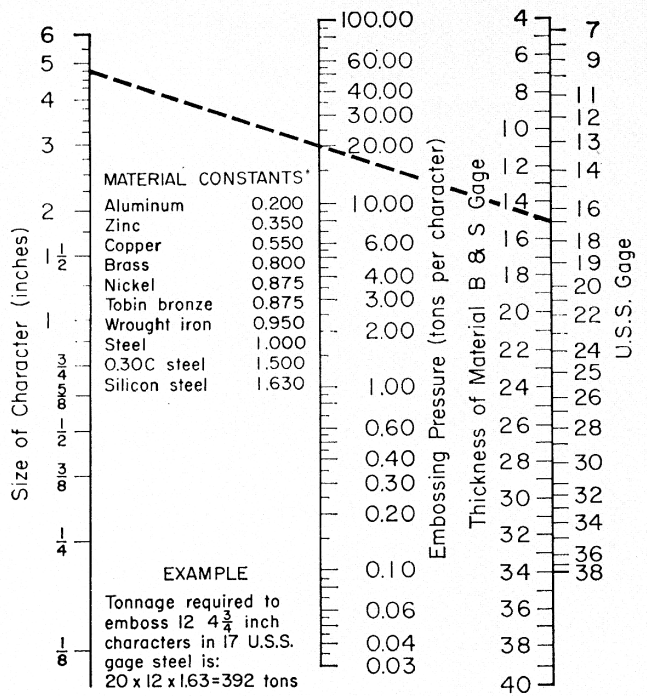
PERCENTAGE OF HEIGHT

Example:	Condensed 33 1/3%	Regular 50%	Extended 66 2/3%
3/8" char.	1/8" wide	3/16" wide	1/4" wide
3/16" char.	1/16" wide	3/32" wide	1/8" wide

Character Size Chart

1/32"	c	5/8"
3/64"	c	
1/16"	C	
3/64"	C	
3/32"	C	3/4"
1/8"	C	
5/32"	C	
3/16"	C	
1/4"	C	7/8"
5/16"	C	
3/8"	C	
7/16"	C	
1/2"	C	1"

Embossing Force Calculator (Male/female dies creating raised characters)

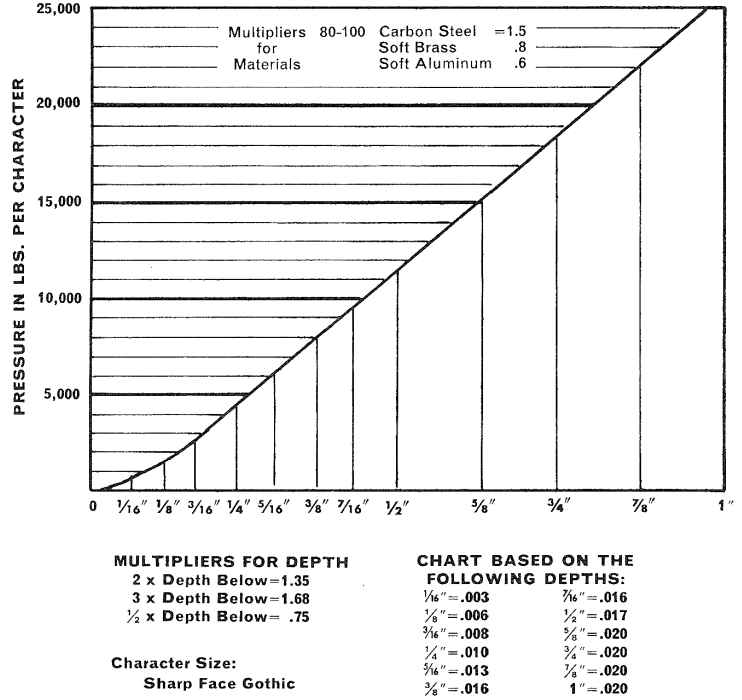


Approximate press capacity, in tons, required to emboss characters of different sizes in sheet steel for various gages. For embossing different sheet materials, multiply the tonnage obtained by the material factor listed to obtain actual required tonnage.

Standard Depth of Engraved Characters

Character Size	Character Depth	Character Size	Character Depth
1/32"	.013	3/16"	.027
3/64"	.014	1/4"	.032
1/16"	.016	9/32"	.035
5/64"	.016	5/16"	.037
3/32"	.018	3/8"	.042
7/64"	.019	7/16"	.050
1/8"	.022	1/2"	.050
5/32"	.022	3/4"	.075

APPROXIMATE STAMPING PRESSURE CHART BASED ON CAST IRON OR MILD STEEL

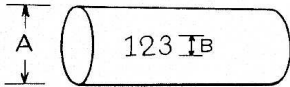


RECOMMENDED HAMMER SIZES FOR SINGLE CHARACTER MARKING

Character Size	Soft Brass or Alum. Normal Depth	Mild Steel Normal Depth	Mild Steel 2X Depth	Anld. Tool Steel Normal Depth	Anld. Tool Steel 2X Depth	Anld. Tool Steel 3X Depth to Background
1/8" or Less	3/4 Lb.	3/4 Lb.	3/4 Lb.	1 Lb.	1 Lb.	1 1/2 Lbs.
3/16"	3/4 Lb.	3/4 Lb.	1 Lb.	1 1/2 Lbs.	1 1/2 Lbs.	2 Lbs.
1/4"	3/4 Lb.	1 Lb.	1 1/2 Lbs.	1 1/2 Lbs.	2 Lbs.	2 1/4 Lbs.
5/16"	1 Lb.	1 1/2 Lbs.	1 1/2 Lbs.	1 3/4 Lbs.	2 1/4 Lbs.	2 1/2 Lbs.
3/8"	1 1/4 Lbs.	1 1/2 Lbs.	1 3/4 Lbs.	2 1/4 Lbs.	2 1/2 Lbs.	3 Lbs.
1/2"	1 1/2 Lbs.	1 3/4 Lbs.	2 1/4 Lbs.	2 1/2 Lbs.	3 Lbs.	3 1/2 Lbs.
5/8"	1 3/4 Lbs.	2 1/4 Lbs.	2 1/2 Lbs.	3 Lbs.	3 1/2 Lbs.	4 Lbs.
3/4"	2 Lbs.	2 1/4 Lbs.	3 Lbs.	3 1/2 Lbs.	4 Lbs.	5 Lbs.
7/8"	2 1/4 Lbs.	3 Lbs.	3 1/2 Lbs.	3 1/2 Lbs.	4 Lbs.	5 Lbs.
1"	2 1/2 Lbs.	3 Lbs.	3 1/2 Lbs.	4 Lbs.	5 Lbs.	6 Lbs.

Above information for estimating purpose ONLY. Determined as approximate figures through series of tests.

CHART FOR DETERMINING MAXIMUM SIZE CHARACTER THAT CAN BE STAMPED ON ROUNDS — FLAT STAMPING



"A" Size of Round	"B" Maximum Size Character	"A" Size of Round	"B" Maximum Size Character	"A" Size of Round	"B" Maximum Size Character
1/8"	1/64"	5/8"	3/32"	1 1/4"	1/8"
3/16"	1/32"	11/16"	3/32"	1 3/8"	1/8"
1/4"	3/64"	3/4"	3/32"	1 1/2"	1/8"
5/16"	3/64"	13/16"	3/32"	1 5/8"	9/64"
3/8"	1/16"	7/8"	1/64"	1 3/4"	9/64"
7/16"	1/16"	15/16"	1/64"	1 7/8"	5/32"
1/2"	5/64"	1"	1/64"	2"	5/32"
9/16"	5/64"	1 1/8"	1/8"		

Larger sizes than indicated in Column "B" would have to be concave.

FRACTION STYLE CHART	
A=overall height B=character size	
STYLE #1	$\frac{\overline{B}}{A} \frac{1}{4}$
STYLE #2	$\frac{\overline{B}}{A} \frac{1}{4}$
STYLE #3	$\frac{A \text{ OR } B}{\overline{A \text{ OR } B}} \frac{1}{4}$
STYLE #4 (our standard)	$\frac{\overline{B}}{A} \frac{1}{4}$
STYLE #5	$\frac{A}{\overline{A}} \frac{\overline{B}}{B} \frac{1}{4}$
STYLE #6	$\frac{A \text{ OR } B}{\overline{A \text{ OR } B}} 1-4$
STYLE #7	$\frac{\overline{B}}{A} 2 \frac{1}{4}$