

## General Marking Guidelines

### Pressure Requirements for Marking

Pressure to mark one Sharp Face character (in tons).

Character Size	Mild Steel	Soft Aluminum	Tool Steel	Character Depth
1/16"	.25	.15	.38	.003"
3/32"	.50	.30	.75	.004"
1/8"	.75	.45	1.13	.006"
5/32"	1.00	.60	1.50	.007"
3/16"	1.88	1.13	2.82	.008"
1/4"	2.10	1.26	3.15	.010"
5/16"	3.00	1.80	4.50	.013"
3/8"	4.00	2.40	6.00	.016"
7/16"	4.75	2.85	7.13	.016"
1/2"	5.70	3.42	8.55	.017"
5/8"	7.50	4.50	11.25	.020"
3/4"	9.25	5.55	13.88	.020"
7/8"	11.00	6.60	16.50	.020"
1"	13.00	7.80	19.50	.020"

These are pressures for Sharp Face characters.

In order to estimate marking pressure requirements, multiply the single character tonnage found above by the number of characters to be marked. To mark half depth, multiply tonnage requirement by 0.75; to mark two times the depth, multiply the tonnage requirements by 1.33; to mark three times the depth, multiply tonnage requirement by 1.7.