

1234567890
 ABCDEFGHIJKLM
 NOPQRSTUVWXYZ
 abcdefghijklm
 nopqrstuvwxyz
 .,:/-!?!%+()

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 ABCDEFGHIJKLM
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 .,:/-!?!%+()

Standard font

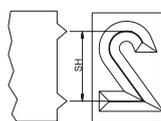
As its standard font, Röltgen uses the font DIN 1451. However, any other font can be used.

DIN 1451 characteristics:

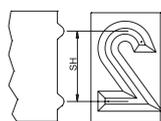
Fig. top left: DIN 1451-2 narrow
 Fig. top right: DIN 1451-3 mid narrow
 Fig. bottom left: DIN 1451-4 mid
 Fig. bottom right: DIN 1451-5 wide

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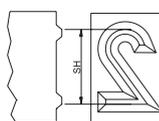
1234567890
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sharp



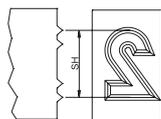
round



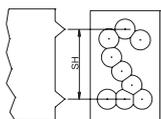
flat

Type of engraving and font size

The engraving style determines the print and the stamping force. e.g. a sharp engraving style requires less stamping force than a flatter one. If low-stress designs are required, pointed engraving is preferable.



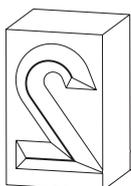
outline



point

The font size (or character height) is always measured from the highest, outermost point of the engraving. It is best to first test the stamp using an ink pad and paper on a hard surface. This will allow you to measure the precise font size.

Left-hand-engraving



stamp

2

print

Right-hand engraving



stamp

2

print

Engraving orientation

The engraving orientation determines whether the print is legible directly or as a mirror image. This is to be taken into account when the medium is to be stamped from the back, but read from the other side (e.g. blister packaging).

Left-hand-engraving = print directly readable

Right-hand-engraving = print not readable (mirror image)

Calculating marking force

In order to select the correct press, it is important to know the required marking force.

This can be determined using the following formula.

$$S = F \times T \times ND$$

S = marking force in N

F = factor (see table)

T = tensile strength in N/mm² of material being marked

ND = number of digits

Example:

Marking 6 characters in 5 mm character size in S 355 J0 (1.0553)

$$S = 17 \times 500 \times 6 = 51000 \text{ N} = 51 \text{ kN}$$

Subject to change. 05-14

character size in mm	fielding factor
1	3,4
1,5	5
2	7
3	10
4	14
5	17
6	20
7	23
8	27
10	32
12	40