



Regulations as stipulated in the relevant standards and guidelines are in principal applicable for stamping flat rolled materials. The subsequent summary states in detail those regulations which are applicable for the requirements of KÖNIG + Co. Hereby the rolling direction has to be considered (stamping has to be legible in rolling direction). These regulations are in principal applicable except for special instructions as mentioned in the customer order.

### Principally stamping has to be carried out by Low Stress stamps!

Under Low Stress stamping you understand spotted automatic stamping or hit stamping without notch effect.

### Material details:

Semifinished products	Thickness	Stamping method	Remark
Blanks/cuttings made of CrNi steels and Ni basis materials	all	Low Stress stamp*	
Blanks, black	all	Low Stress stamp*	Surface to be ground before stamping
Blanks, aluminium	5 mm	colour marking	at ADW 6/1
	> 5 mm	Low Stress stamp*	at ADW 6/1

### Stamping field: details

Blank diameter	Position of stamping field –referring to the inside rim of the stamping field (see sketch)	Letter size	Size stamping field
* < 150 mm	just engraving or colour marking	accepted	
150 - 500 mm	Blank centre	5 – 6 mm	Approx. 60 x 60 mm
500 - 1000 mm	100 mm out of centre	8 mm	Approx. 80 x 80 mm
1000 – 2000 mm	200 mm out of centre		
> 2000 mm	200 mm out of centre		
Divided blanks	In the centre of each blank half in a distance of 350 mm to the straight cutting edges		

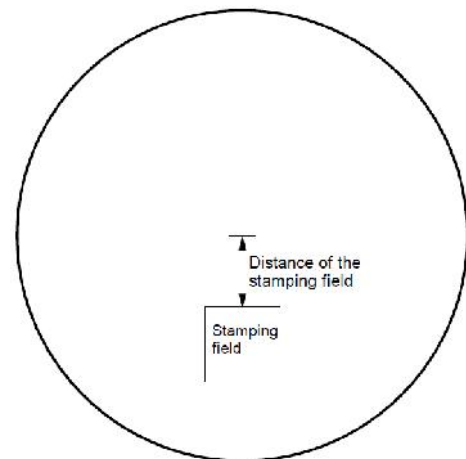
### Shape of the stamping field:

The stamping field has to be arranged in a quadratic position. The distance between the single letters should not exceed  $\frac{1}{2}$  letter size. Respective questions have to be clarified.

### Depth of the stamping:

To be measured by a depth gauge with a sharpened measuring pin

Blank thickness	Stamping depth
20 mm	0.2 – 0.3 mm
> 20 mm	0.3 – 0.5 mm



Sketch for the stamping field position

### Additional specifications:

- In general no stamping is needed for materials which require just a works certificate 2.2
- All material grades, as mentioned in the customer order, have to be stamped completely.