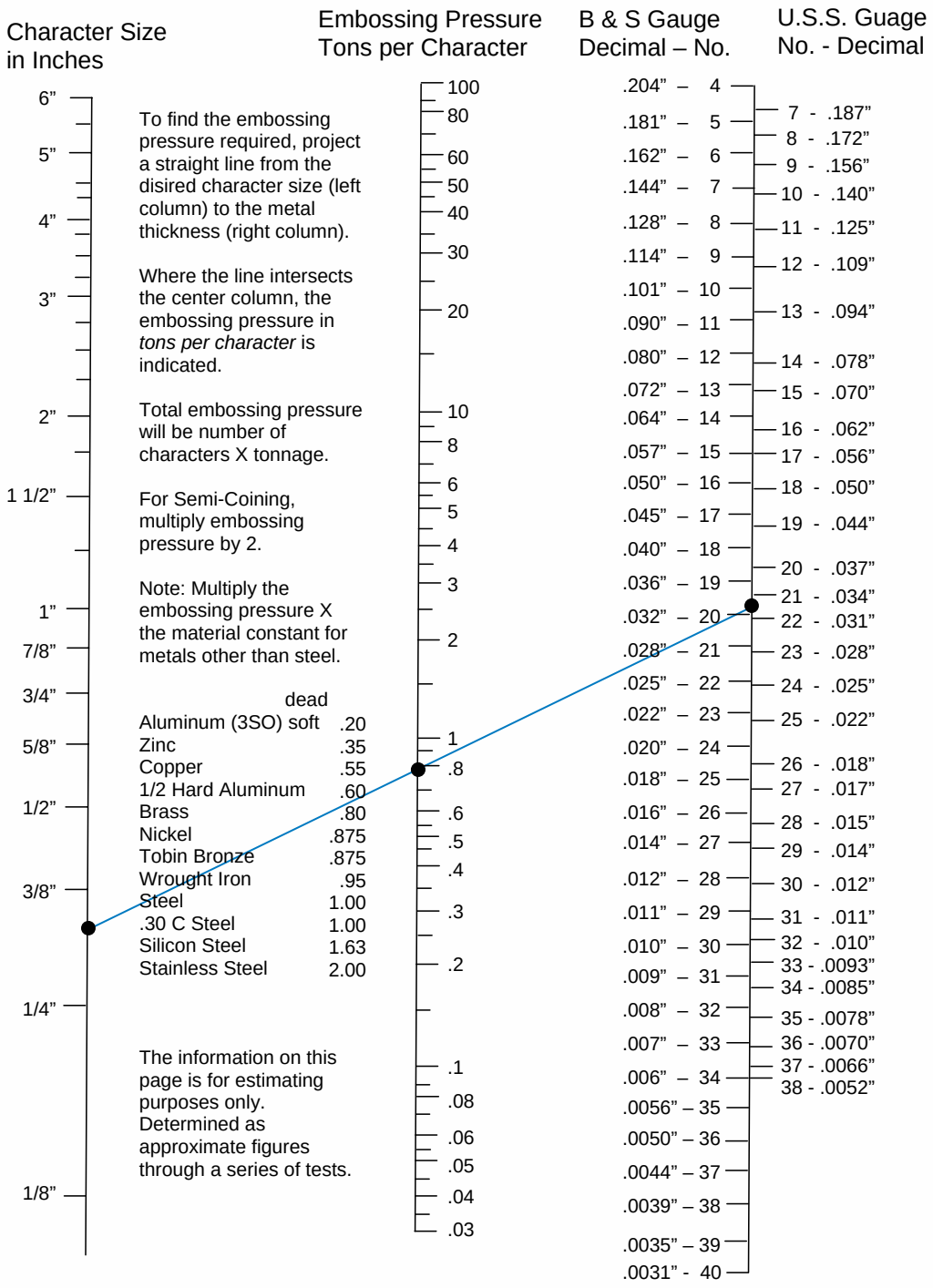
Embossing Pressure Chart For Male and Female Dies



To find the embossing pressure required, project a straight line from the disired character size (left column) to the metal thickness (right column).

Where the line intersects the center column, the embossing pressure in *tons per character* is indicated.

Total embossing pressure will be number of characters X tonnage.

For Semi-Coining, multiply embossing pressure by 2.

Note: Multiply the embossing pressure X the material constant for metals other than steel.

	dead
Aluminum (3SO) soft	.20
Zinc	.35
Copper	.55
1/2 Hard Aluminum	.60
Brass	.80
Nickel	.875
Tobin Bronze	.875
Wrought Iron	.95
Steel	1.00
.30 C Steel	1.00
Silicon Steel	1.63
Stainless Steel	2.00

The information on this page is for estimating purposes only. Determined as approximate figures through a series of tests.

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