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Product Overview

Roll Marking Options by Application

1. Mark Around the Periphery: 860/260, 400, 960, Mite-E-Roll
2. Mark Along the Axis of a Round Part or on a Flat: 860, 260, 400
3. Mark Thin Wall or Tubular: 860, 260, 400 with mandrel support
4. Mark Thin Wall or Tubular: Mite-E-Roll without mandrel support
5. Mark Large Diameter - 3" to 20": 400, 960
6. Mark Medium Diameter - 3/8" to 5": 860, 260, 400
7. Mark Small Diameter - 1/4" to 1 1/2": Mite-E-Roll
8. Mark High Speed In-Line: Mite-E-Roll
9. Mark Continuous High Speed Round Bars or Hex Stock: Bar Stock Marking Systems

Examples of Marks by Machine

Barstock Marking

860 Roll Marking

Mite-E-Roll

400 Series Hydraulic
Basic Roll Marking: For roll marking, the mark is “rolled” onto the part. It is an economic solution in applications where tonnage requirements make a press too costly. Also, a practical method where fragile parts would be damaged by stamping pressure. This method can be used on both flat and round parts.

Roll Marking Sequence

Step #1 - Part in position to be marked. May require part locating fixture or roll cradle as shown.

Step #2 - Marking die approaches and contacts part. Columbia Marking Tools’ “Seek & Find” pressure system assures constant marking pressure on the part at all times.

Step #3 - Marking die moves across part. Approximately one character is in contact with the surface of the part at any time. Round part rolls with die in roll cradle.

Step #4 - After moving the length of the slide stroke the roll marking die retracts from the part.

For all Columbia roll marking machines we suggest using quality Columbia Marking Tools dies and inserts:

✓ Individual type
✓ Segment type with multiple characters - company logos and special symbols
✓ Timing marks
✓ Roll dies with designs (knurling)
✓ Roll marking numbering dies
Roll Marking Methods

Marking round parts: This method uses a type holder with or without a roll cradle.

Marking flat parts: This method uses a roll type holder and part locating fixture.

A roll type holder (shown at left) is also used for parts with a curved surface or large radius.

Marking hollow round parts: This method uses a type holder and mandrel, or other internal support.

Diameter to diameter rotary roll marking machines have a motorized mandrel to allow for extremely long marking legends.

Columbia Marking Tools specializes in custom marking applications. The following features can be integrated into our marking machines:

- Automated feeding system
- Automated cycle (part present cycle start)
- Numbering heads
- Serializing and automated date coding
- Custom roll dies
- Custom roll type holders

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Roll Marking Machines

Adjustable Slide stroke = 3 1/2” for the Model 860 and 6” for the Model 260.

The Slide-Stroke should be longer than the marking legend.

Dual, anti-tie down anti-repeat, palm buttons

Cast iron, T-slot, adjustable table (shown with roll cradle)

Heavy duty machine base

Dovetail quick-change tooling

Ram cylinder = Approach stroke

Customized turn-key systems:
- Part locating fixture
- Slide feed chase
- Feeding systems
- Communications
- Vision verification

Industrial grade air filter, regulator, pressure gauge, lubricator, and shut-off valve

Connect to 1/2” air line and machine is ready to mark

Optional casters

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Retro-fit roll marking units are easily incorporated into production equipment:
✓ Air piloted or Electrically controlled
✓ Variable pressure ranges
✓ Position sensors available for all motions
✓ Choice of approach and slide stroke lengths
✓ Flexible tooling options

Ram cylinder
Position sensors or limit switches for advance and retract of slide and ram cylinders

Four bolt mounting
Dovetail quick-change tooling
Adjustable stroke, internal die slide system (3 1/2” maximum)

2D and 3D drawing files available

Standard and custom tooling available. Shown here with random select numbering head.
### COLUMBIA MARKING TOOLS

### Basic Systems

#### How to Order

<table>
<thead>
<tr>
<th>Model/Feature</th>
<th>Symbol</th>
<th>Example</th>
</tr>
</thead>
<tbody>
<tr>
<td>860 - 3 1/2&quot; marking legend length (Slide Stroke)</td>
<td>860</td>
<td>860BM-A43-20-RSS9</td>
</tr>
<tr>
<td>260 - 5&quot; marking legend length (Slide Stroke)</td>
<td>260</td>
<td></td>
</tr>
<tr>
<td>Bench Style</td>
<td>B</td>
<td></td>
</tr>
<tr>
<td>Floor Style</td>
<td>F</td>
<td></td>
</tr>
<tr>
<td>Retro-Fit Unit</td>
<td>R</td>
<td></td>
</tr>
<tr>
<td>Double Palm Buttons - Air (anti-tie down anti-repeat)</td>
<td>M</td>
<td></td>
</tr>
<tr>
<td>Double Palm Buttons Electric (ergonomic touchless)</td>
<td>T</td>
<td></td>
</tr>
<tr>
<td>Automatic Air Pilot Cycling with electric cycle start</td>
<td>E</td>
<td></td>
</tr>
<tr>
<td>Automatic (completely electrically controlled)</td>
<td>K</td>
<td></td>
</tr>
<tr>
<td>Mark Pressure Min 251# - Max 1006# (air powered)*</td>
<td>A10</td>
<td></td>
</tr>
<tr>
<td>Mark Pressure Min 555# - Max 2250# (air powered)*</td>
<td>A22</td>
<td></td>
</tr>
<tr>
<td>Mark Pressure Min 555# - Max 4390# (air powered)*</td>
<td>A43</td>
<td></td>
</tr>
<tr>
<td>Mark Pressure Min 555# - Max 5300# (air powered)*</td>
<td>A61</td>
<td></td>
</tr>
<tr>
<td>Mark Pressure Max 1884# (hydraulically powered)**</td>
<td>H18</td>
<td></td>
</tr>
<tr>
<td>Mark Pressure Max 4980# (hydraulically powered)**</td>
<td>H49</td>
<td></td>
</tr>
<tr>
<td>Mark Pressure Max 6000# (hydraulically powered)**</td>
<td>H80</td>
<td></td>
</tr>
<tr>
<td>1&quot; Max Approach Stroke</td>
<td>10</td>
<td></td>
</tr>
<tr>
<td>2&quot; Max Approach Stroke</td>
<td>20</td>
<td></td>
</tr>
<tr>
<td>3&quot; Max Approach Stroke</td>
<td>30</td>
<td></td>
</tr>
<tr>
<td>Ram Returned L/S Option</td>
<td>R1</td>
<td></td>
</tr>
<tr>
<td>Ram Returned and Extended L/S Option</td>
<td>R2</td>
<td></td>
</tr>
<tr>
<td>Ram Returned Position Switch Option***</td>
<td>R3</td>
<td></td>
</tr>
<tr>
<td>Ram Returned and Extended Position Switch Option***</td>
<td>R4</td>
<td></td>
</tr>
<tr>
<td>No Switches</td>
<td>R9</td>
<td></td>
</tr>
<tr>
<td>Slide Returned L/S Option</td>
<td>S1</td>
<td></td>
</tr>
<tr>
<td>Slide Returned and Extended L/S Option</td>
<td>S2</td>
<td></td>
</tr>
<tr>
<td>Slide Returned Position Switch Option***</td>
<td>S3</td>
<td></td>
</tr>
<tr>
<td>Slide Returned and Extended Position Switch Option***</td>
<td>S4</td>
<td></td>
</tr>
<tr>
<td>No Switches</td>
<td>S9</td>
<td></td>
</tr>
</tbody>
</table>

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**One size does not fit all applications.**

CMT makes it easy to select the right options for your application. Please choose the features that meet your requirements, from the marking legend length to the system power.

* Air units rated at 80 PSI
** Hydraulic units rated at 600 PSI
*** Standard DC connection

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**Static Stamping**

Per Character

- **Carbon Steel (17-20 Rc)**
- **1018 Steel**
- **Soft Brass**
- **Cast Aluminum**

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**27430 Luckino Dr, Chesterfield MI 48047 * 586.949.8400 * 586.949.8401 Fax**
Roll Marking:
400 Series

Hydraulic Roll Marking
9 or 18 tons

- Graduated slide stroke control bar
- High/Low pressure switch selector
- Dual anti-tie down anti-repeat cycle start palm buttons/ring guards (special location)
- Up to 90 cycles/minute
- 9" - 15" die space
- Standard roll carriages and roll type holders available (for marking flat parts)
- Standard flat type holders available (for marking round parts)

- NEMA 12 electrical control panel with safety disconnect
- Integral hydraulic power unit
- Dual anti-tie down anti-repeat cycle start palm buttons/ring guards (special location)
- Heavy duty sealed roller bearings
- Table height lock
- Table height adjustment wheel

- Heavy duty machine frame
- Hydraulic power unit with 5HP TEFC 230/460 VAC 3 phase electric motor, high performance oil pump, oil filtration system, 27 gallon reservoir, directional and pressure valves, temperature, level and pressure gauges
- 1/2 to 18 tons of force
- NEMA 12 electrical control panel with safety disconnect
- Heavy duty sealed roller bearings

All dimensions are approximate. Please request current drawing of configuration required.
Columbia Marking Tools specializes in custom applications, the following features can be integrated into our hydraulic roll marking machines:

✓ Automated feeding system
✓ Automated cycle (part present cycle start)
✓ Numbering heads
✓ Serializing and automated date coding
✓ Custom roll dies

For all Columbia roll marking machines we suggest using quality Columbia Marking Tools dies and inserts:

✓ Individual type
✓ Segment type with multiple characters for ease of setup and changeover
✓ Company logos and special symbols

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Barstock Marking Machine

2 or 4 Sided

- Heavy duty machine style base
- Continuous duty feed system
- Adjustable part locating guides with sealed bearings for trouble free operation
- Micro-mark depth adjustment
- Heavy duty GEAR DRIVEN marking rollers
- Independent pressure rams with self centering backup support rolls (one lead screw adjusts backup & marking roll simultaneously)
- Variable speed high performance drive with “set-up jog” feature
Barstock Marking Machine

- Switch for backward and reverse drive
- Oil bath transmission
- Central lubrication manifold with all internal points piped to external access lube point
- Hardened & ground drive shafts with heavy duty sealed bearings
- Continuous rated motor 2 HP 230 V/1750 RPM

210 ft per min
3/8” to 3” Hex and Round stock size

- Electrical control panel with DC variable speed controller and drive, power transformer, fused safety disconnect, master start/stop and all component devices terminated and wired
- OSHA required guarding complete with access panels and hinged tool access gate, latched, mounted and switched for “no operation”

Operation as seen through “Easy-View” guarding
High Speed Mite-E-Roll

Model 2000 Mite-E-Roll

- Reduced low force marking method with opposing directional slides
- Marks up to 4,000 parts per hour, depending on part diameter
- Air powered ram and dual action slide
- Gear timed cross slides, for accurate mark repeatability
- Fiber optic (adjustable) part present cycle switch
- Cross slide start and stop proximity switches
- Optional adjustable machine style base
- Part “Stop-In-Mark Station” locator finger
- All box ways with standard industrial bearings
- Quick change stamp holder mounting
- Air inline OSHA required power out valve
- All necessary air control valves

Prewired J/C box or optional machine control panel
Air prep unit and pressure regulator with OSHA approved lockout
Fiber optic part present cycle switch
Ram cylinder (2) marking pressure options low/high
High Speed Mite-E-Roll

Part backup may also hold stamps

Quick change stamp holder

Electrical control panel with 110vac, programmable functions with look-up menu for program review, and self diagnostics

Automated load and unload track available upon customer request

Macho-Roll for larger parts

Shown here with manual load and auto-eject function
Rotary Marking Head

- Industrial duty rated 180° "Rotary Drive" allows for increased marking length capacity. Up to 7.5" maximum marking.

Rotary Roll Marking

- Ram Cylinder
- Master Fixture Plate
- Palm Buttons
- Machine Base

All dimensions are approximate. Please request current drawing of configuration required.

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Machine Features:
✓ Heavy duty (special angle) floor style machine frame
✓ Machine surface and tapping plate for special fixturing
✓ High power “3 ton” at 80 psi marking ram
✓ All heat treated high strength square press ram
✓ Quick change dovetail tooling mount
✓ Modular air inline air filtration, pressure regulator and lubricator
✓ OSHA required air inline main power lockout valve (1/2” NPT inlet)
✓ 110 VAC plug in power cord (10’)
✓ Ergonomic “touchless” palm buttons with protective ring guards
✓ All necessary air logic control valves (manifold mounted)
✓ Machine program control panel including: Machine mounted NEMA 12 rated enclosure, fused power supply and PLC permanent memory programmable control

Rotary Marking Head

Marks legend lengths up to 7.5”
Tooling For Round Parts

DM and TM Series Step type holders use a retaining clip to secure type and/or logo dies in holders. This standard type lock allows remarkable time savings when changing marking legends.

Series DM holders
✓ Dovetail mounted holder
✓ For use with S style standard type
✓ “Quick Change” tooling for Model 860, 260, Mite-E-Roll and 960 Rotary roll marking machines

<table>
<thead>
<tr>
<th>Catalog No.</th>
<th>Max Number of Characters</th>
<th>Dim</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1/16</td>
<td>3/32</td>
</tr>
<tr>
<td>DMA-20</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>DMA-30</td>
<td>48</td>
<td>32</td>
</tr>
<tr>
<td>DMB-30</td>
<td>16</td>
<td>16</td>
</tr>
<tr>
<td>DMC-30</td>
<td>12</td>
<td></td>
</tr>
</tbody>
</table>

DM and TM Series use CMS Type

Custom Mandrel for support when marking hollow parts, features:
✓ Accurately sized for different diameter parts
✓ Interchangeable
✓ Hardened and ground

Free turning hollow part, with mandrel for support

Straight type holder shown with dovetail mounting
Series TM holders
✓ T-slot mounted holder
✓ For use with S style standard type
✓ General multipurpose mounting
✓ For use in 400 Hydraulic series roll marking machines

<table>
<thead>
<tr>
<th>Catalog No.</th>
<th>Max Number of Characters</th>
<th>Dim</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1/16</td>
<td>3/32</td>
</tr>
<tr>
<td>TMA-20</td>
<td>32</td>
<td>21</td>
</tr>
<tr>
<td>TMA-30</td>
<td>48</td>
<td>32</td>
</tr>
<tr>
<td>TMB-30</td>
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<td>16</td>
</tr>
<tr>
<td>TMC-30</td>
<td></td>
<td>12</td>
</tr>
</tbody>
</table>

Holder & stamps
Roll Cradles mounted on the work table of a roll marking machine provide a free turning rest for marking round or conical parts.
✓ Standard sizes available for various diameter parts
✓ Custom roll cradles are useful for conical parts or parts having several diameters

<table>
<thead>
<tr>
<th>Catalog No.</th>
<th>DIM</th>
<th>Dim over rollers to mounting face</th>
<th>For Part Diameters</th>
</tr>
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<tbody>
<tr>
<td></td>
<td></td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>RC-0</td>
<td>3/4</td>
<td>1</td>
<td>3/4</td>
</tr>
<tr>
<td>RC-1</td>
<td>1</td>
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<td>2</td>
</tr>
<tr>
<td>RC-2</td>
<td>1</td>
<td>2</td>
<td>2</td>
</tr>
<tr>
<td>RC-3</td>
<td>1 1/4</td>
<td>2 1/4</td>
<td>2 3/32</td>
</tr>
<tr>
<td>RC-4</td>
<td>1 1/4</td>
<td>2 1/4</td>
<td>2 1/8</td>
</tr>
</tbody>
</table>
Roll Carriages:
Are used on roll marking machines to hold a roll die or roll type holder when marking on flat surfaces or contoured surfaces. The basic principle is to let the roll die turn freely while in contact with the work piece, and to turn the roll die, automatically, to its starting position once the die is released from the contact with the work piece.

- Rugged construction for long, trouble-free operation
- All components interchangeable, including stock bearings
- Superior dovetail mounting
- For use with roll type holders shown below
- For use with custom roll dies, please specify requirements for quotation

Roll Type Holders:
Developed to efficiently mark both flat and contoured surfaces, are designed to hold individual step style wedge type or combinations of wedge type, logo-type and segment dies.

- Step in the cover plate retains the type in the holder
- “Take-up” screw holds the type in perfect alignment
- Quick release of cover plate allows change-over of marking legends

<table>
<thead>
<tr>
<th>Catalog No.</th>
<th>Character Sizes</th>
<th>Dim A</th>
<th>Dim B</th>
<th>Dim C</th>
<th>Use in Roll Carriage</th>
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<tbody>
<tr>
<td>RMA-2</td>
<td>1/32 1/64 1/32 1/8</td>
<td>7/32</td>
<td>2</td>
<td>3/4</td>
<td>DCA-75</td>
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<td>RMA-3</td>
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<td>7/32</td>
<td>3</td>
<td>3/4</td>
<td>DCA-75</td>
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<tr>
<td>RMB-2</td>
<td>5/32 3/16</td>
<td>9/32</td>
<td>2</td>
<td>1</td>
<td>DCA-100</td>
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<tr>
<td>RMB-3</td>
<td>5/32 3/16</td>
<td>9/32</td>
<td>3</td>
<td>1</td>
<td>DCA-100</td>
</tr>
<tr>
<td>RMC-2</td>
<td>1/4</td>
<td>11/32</td>
<td>2</td>
<td>1</td>
<td>DCA-100</td>
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<tr>
<td>RMC-3</td>
<td>1/4</td>
<td>11/32</td>
<td>3</td>
<td>1</td>
<td>DCA-100</td>
</tr>
</tbody>
</table>

RMA Series uses CMW Type
Marking by means of a roll die is one of the fastest and most efficient methods known. Roll dies, used in manually operated marking fixtures, hand, air, and hydraulic marking machines, bar markers, and special purpose marking machines, solve a large variety of marking needs.

Due to the relatively small point of contact, the roll marking method requires only a fraction of the pressure that would be needed to mark the same legend by a press method.

The roll die marking method is used exclusively when marking uneven surfaces by employing COLUMBIA roll marking machines. In contouring, the machine allows the roll die to follow an uneven surface while, simultaneously, keeping the impression depth uniform.

Lettering Knurl (Round Die)
D = diameter
W = width
D_b = diameter of bore
K = width of keyway
K/2 = depth of keyway
(D x W x D_b x K x K/2)
Ordering Stamps:
✓ To order individual LETTERS and FIGURES add suffix of actual letter to catalog number
✓ To order BLANK SPACERS add suffix of “.00”
✓ To order PUNCTUATION MARKS add suffix shown below
✓ To order SYMBOLS add $ with symbol # from table

<table>
<thead>
<tr>
<th>Punctuation Marks</th>
<th>Mark</th>
<th>Symbol</th>
<th>Suffix</th>
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</thead>
<tbody>
<tr>
<td>Space</td>
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<td>-00</td>
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<tr>
<td>Dash</td>
<td></td>
<td></td>
<td>-DD</td>
</tr>
<tr>
<td>Period</td>
<td></td>
<td></td>
<td>-PP</td>
</tr>
<tr>
<td>Comma</td>
<td></td>
<td></td>
<td>-CC</td>
</tr>
<tr>
<td>Diagonal</td>
<td>/</td>
<td></td>
<td>-SS</td>
</tr>
<tr>
<td>Ampersand</td>
<td>&amp;</td>
<td></td>
<td>-AA</td>
</tr>
<tr>
<td>Number Sign</td>
<td>#</td>
<td></td>
<td>-NN</td>
</tr>
<tr>
<td>Number Sign</td>
<td>O</td>
<td></td>
<td>-TT</td>
</tr>
<tr>
<td>Multiplication</td>
<td>x</td>
<td></td>
<td>-MM</td>
</tr>
<tr>
<td>Equale Sign</td>
<td>=</td>
<td></td>
<td>-EE</td>
</tr>
<tr>
<td>Colon</td>
<td>:</td>
<td></td>
<td>-LL</td>
</tr>
<tr>
<td>Plus Sign</td>
<td>+</td>
<td></td>
<td>-UU</td>
</tr>
<tr>
<td>Asterisk</td>
<td>*</td>
<td></td>
<td>-RR</td>
</tr>
<tr>
<td>Percent Sign</td>
<td>%</td>
<td></td>
<td>-QQ</td>
</tr>
</tbody>
</table>

Ordering Logo Dies and Segments:
✓ To order LOGO DIES (multiple character stamps) for Groove style G and Step style S stamps, add the prefix L and denote the actual legend required
✓ To order SEGMENT DIES (multiple character wedge stamps) for Wedge style W, add the prefix S and denote the actual legend required

Legend Length - Multiply the number of characters by the character size, count spaces and punctuation as 1/2 a character.

<table>
<thead>
<tr>
<th>L</th>
<th>CMG</th>
<th>09</th>
<th>PAT. PEND</th>
</tr>
</thead>
<tbody>
<tr>
<td>Logo Die</td>
<td>Style</td>
<td>Char Size</td>
<td>Stamp reads “PAT. PEND”</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>S</th>
<th>CMW</th>
<th>13</th>
<th>MADE IN USA</th>
</tr>
</thead>
<tbody>
<tr>
<td>Segment Die</td>
<td>Style</td>
<td>Char Size</td>
<td>Stamp reads “MADE IN USA”</td>
</tr>
</tbody>
</table>

27430 Luckino Dr, Chesterfield MI 48047 * 586.949.8400 * 586.949.8401 Fax
# Roll Marking: Machines and Tooling

## Style W

<table>
<thead>
<tr>
<th>Char Size</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>Catalog</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/32</td>
<td>1/16</td>
<td>1/4</td>
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**Wedge Style Type:**
For use in RM Series holders

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**Groove Style Type:**
For use in type holders

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**Step Style Type:**
For use in DM and TM Series holders

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