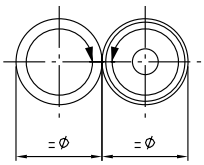
# Marking Applications

### Allocation of the ZEUS marking tool series according to the marking types

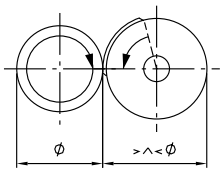
| Tool Type | Marking Roll | Marking Type | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| | | S | SL | SR | SLR | W | WL | WR | WLR |
| ZEUS MC1 | No. 40 | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ |
| ZEUS MCC1 | No. 40 | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ | ✓ |
| ZEUS MR1 | No. 41 | ✓ | x | x | x | ✓ | x | x | x |
| ZEUS MRS1 | No. 42 | ✓ | x | x | x | ✓ | x | x | x |

**No. 40**
Marking roll continuously rotating



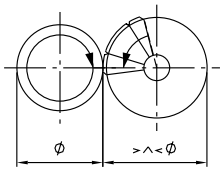

Work piece Marking roll

**No. 41**
Marking roll partially rotating

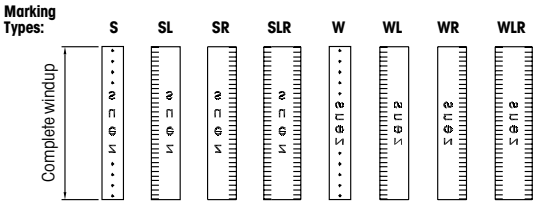



Work piece Marking roll

**No. 42**
Marking roll partially rotating




Work piece Marking roll




The marking types indicated by an x cannot be produced with this tool series.

# Approximate Values for Feed and Speed Rate

### Continuous Roll Marking

| Material | Vc (m/min) | f (mm/rev.) |
|---|---|---|
| Free-cutting steel | 30 | 0,1 - 0,15 |
| Stainless steel | 25 | 0,08 - 0,12 |
| Brass | 40 | 0,1 - 0,15 |
| Aluminium | 35 | 0,1 - 0,15 |

### Spring Return Marking (Single pass)

#### 1. In feed method with rotating work piece

| Material | Vc (m/min) | f (mm/rev.) |
|---|---|---|
| Free-cutting steel | 5 | Rapid power traverse |
| Stainless steel | 5 | Rapid power traverse |
| Brass | 5 | Rapid power traverse |
| Aluminium | 5 | Rapid power traverse |

#### 2. In feed method with stationary work piece

1. Stop spindle
2. Engraving of the marking roll during feed
3. Slow rotation of the spindle
4. Return of the marking roll

**Note:**
The values above are approximate values only. Sufficient cooling and lubrication during the marking process is highly recommended.

**Depth of imprint:** Standard imprint depth is 0,075 mm relative to radius / 0,15 mm relative to diameter.