

The print-out is not subject to the modification service.

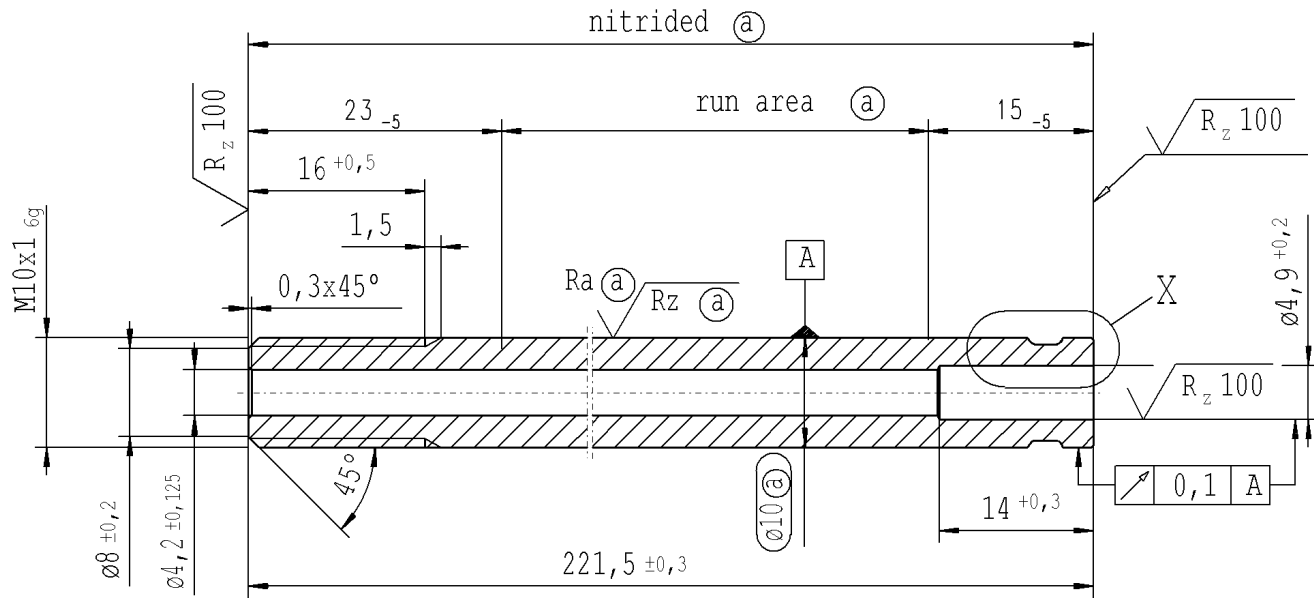
Intended for internal and supplier use

EN

Ident. Doc.: L13

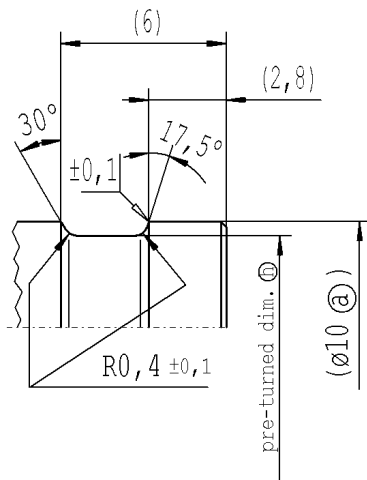
- Ⓐ piston rod processing per STAB-Spec. 10028959 tab.I
- ⓓ knurl-profile manufactured with knurl roll DIN 82 - RAA 0,5

100% cleanliness of through hole

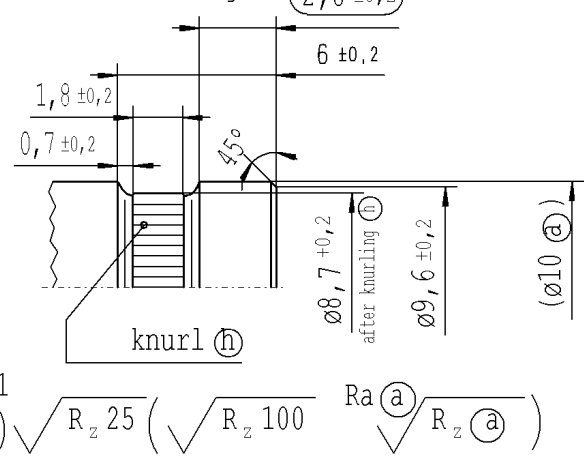


Control dimension!  
100 % visual checking

X 5:1  
before knurling



X 5:1  
after knurling



RELEASE  
for supplier  
company Zhang Shi

AIAG CQI-standards acc. to STAB-Spec. 10027692							Environmental protection acc. to STAB-Spec. 10005649											
DE: X	EN: X	ES:	IT:	PR:	FR:	RO:	CAD created document; handwritten changes not permitted				Material:	All dimensions are in mm		Identification of important characteristics		Date	Name	
new	INITIAL RELEASE	Ø4,2 ± 0,125	221,5 ± 0,3	changed tolerances	run area	marking groove removed					1.1193					Drawn by	12.02.2008	Höfer
old	-	Ø4,2 ± 0,15	104,5 ± 0,3	-	hardness	-					S45C JISG 4051	Scale:	Dimensions without tolerances		Checked	13.06.2014	Klinkner	
Field	-	D6	D/4-5	B-E/1-6	F 4	-					Edge tolerances acc. to DIN ISO 13715	(Original DIN A3)	DIN ISO 2768-mK					
Date/Name	12.02.2008 Höfer	27.02.2008 K.Marx	09.06.2008 Hein	07.01.2009 Hein	23.7.10 KeDelh.	13.06.2014 Hein					Surface finish	DIN ISO 1302		Document No.:		10152095		
Chg. No.	-	-	-	570251	581810	614234					Replaces:							
Rev.	0	1	2	3	4	5					STABILUS		PISTON ROD		Material No.:		008881	

$\sqrt{+0,2}$   $\sqrt{-0,2}$   $\sqrt{\pm 0,1}$   $\sqrt{R_z 25}$  ( $\sqrt{R_z 100}$   $\sqrt{Ra \text{ Ⓐ}}$   $\sqrt{R_z \text{ Ⓐ}}$ )