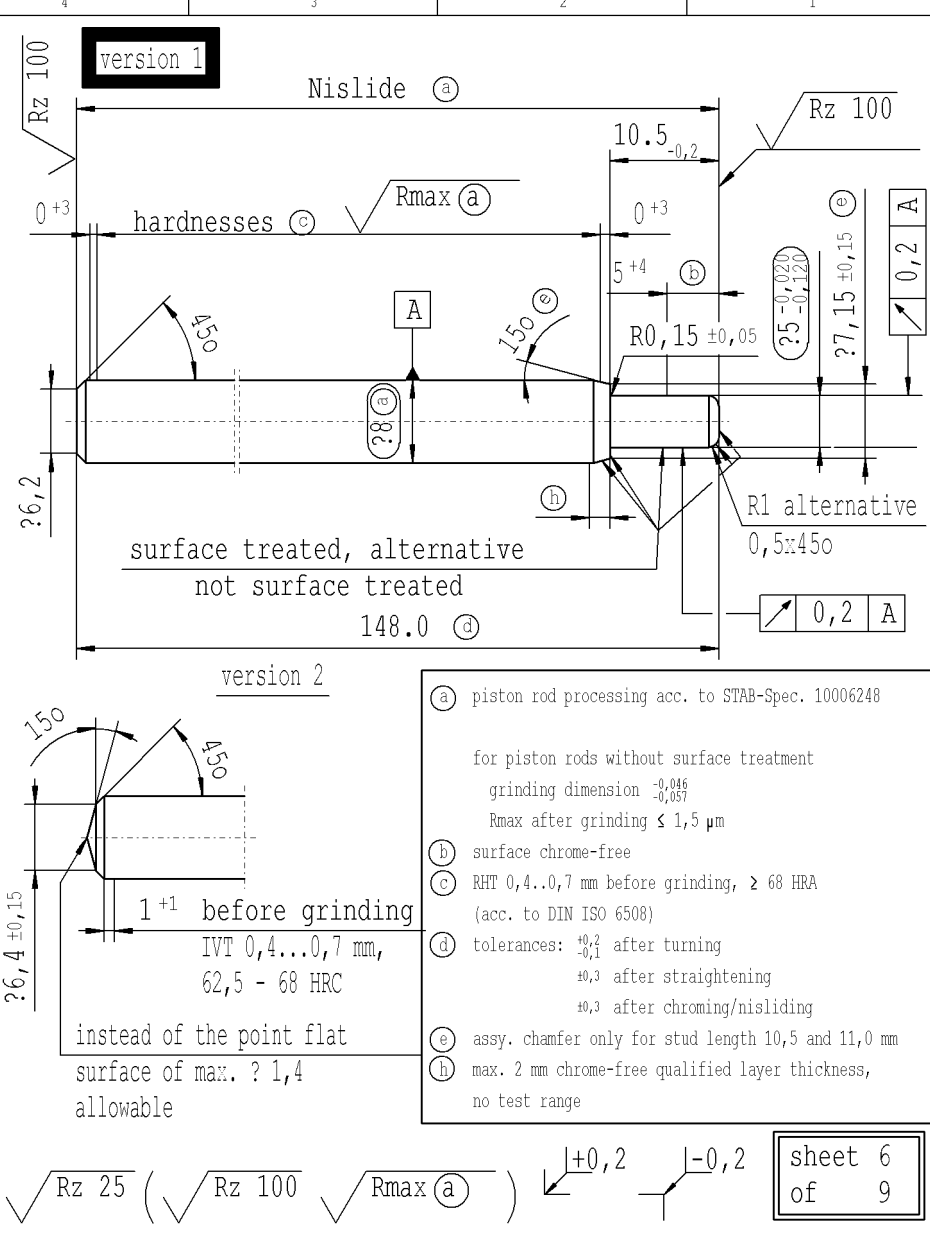


Ident. Doc.: SN 53.11#040391max. 22/10/2015 - 817

F	supp. No.	material no.					A	B	F
		surface treatment processing acc. to STAB-Spec. 10006248							
		table IV Nislide black	table V Nislide light	table VIII Nislide black	table X Nislide "G"	table XVI Nislide black			
	197	0909NC			0909NC		126.0	10.5	1
	199	1806NQ			1806NQ		148.0	10.5	1
	202	6463NK					130.5	16.5	1
	203	6595NC			6595NC		88.0	10.5	1
	204	6862NO			6862NO		121.0	10.5	1
	206			9024NG			213.0	10.5	2
	207	9324NM			9324NM		96.0	10.5	1
	208	6003NU			6003NU		90.0	10.5	1
	210	4546PI			4546PI		405.0	10.5	1
	211			4814PP			501.0	10.5	1
	213	5363PR			5363PR		396.0	10.5	1
	217	1148QT					162.0	16.5	1
	218	8903PO			8903PO		195.0	10.5	1
	223	3249RO			3249RO		240.0	10.5	1
	227	2112TU			2112TU		141.0	10.5	1
	228	2718UZ			2718UZ		186.0	10.5	1
	236	4506UM			4506UM		106.0	10.5	1
	241	5682UX			5682UX		82.0	10.5	1
	242	9414UK			9414UK		177.0	10.5	1
	243	2018ED			2018ED		63.0	10.5	1
	249			4202VW			86.0	10.5	1
	250	4686VH					171.0	10.5	1
	253	7202VZ			7202VZ		279.0	10.5	1
	255	1146WF					109.5	10.5	1
	258	3729WZ			3729WZ		128.0	10.5	1
	261	2802YL			2802YL		94.5	10.5	1
	262	2861ZD					189.0	10.5	1
	264	3007ZD					318.0	10.5	1
	265	1857ZO			1857ZO		119.0	10.5	1



- (a) piston rod processing acc. to STAB-Spec. 10006248 for piston rods without surface treatment grinding dimension $-0,046$ $-0,057$ Rmax after grinding $\leq 1,5 \mu\text{m}$
- (b) surface chrome-free
- (c) RHT 0,4..0,7 mm before grinding, ≥ 68 HRA (acc. to DIN ISO 6508)
- (d) tolerances: $\pm 0,1$ after turning $\pm 0,3$ after straightening $\pm 0,3$ after chroming/nisliding
- (e) assy. chamfer only for stud length 10,5 and 11,0 mm
- (h) max. 2 mm chrome-free qualified layer thickness, no test range

instead of the point flat surface of max. $\pm 1,4$ allowable

$\sqrt{Rz 25}$ ($\sqrt{Rz 100}$ $\sqrt{Rmax (a)}$) $\swarrow +0,2$ $\searrow -0,2$

sheet 6 of 9

AIAG CQI-standards acc. to STAB-Spec. 10027692							Environmental protection acc. to STAB-Spec. 10005649				
DE: X	EN: X	ES: X	IT:	PR:	FR:	RO:	CAD created document handwritten changes not permitted				
new	surface treated ...	2802YL Tab4+10	0,5x450 alternative R1	R1 alternative 0,5x450	chrome DOK 1021401	Tab.XVI	Material: mat.no. 010731				
old	-	Tab4	0,5x450	0,5x450 alternative R1	-	-	All dimensions are in mm Identification of important characteristics				
Field	D-E/1-3	Pos.261	D-E/1	D-E/1	Pos 78;90;115;137;185	-	Scale: (Original DIN A3) 2:1 Dimensions without tolerances DIN ISO 2768-mK				
Date/Name	23.05.2006 Sch?nberger	21.11.06 H?fer	28.05.2008 Hein	19.03.2009 Hein	06 08 2014 H?fer	07.10.2015 H?fer	We reserve all rights to this document, to any patents or patent registrations related hereto, and to the duplication, rettransmission by third parties and misc. use. Any use of this document is not permitted without the written consent of STABILUS.				
Chg. No.	550622	553536	565550	571413	615932	629279	Document No.: 10003762				
Rev.	44	45	46	47	48	49	Material No.:				
STABILUS							PISTON ROD				