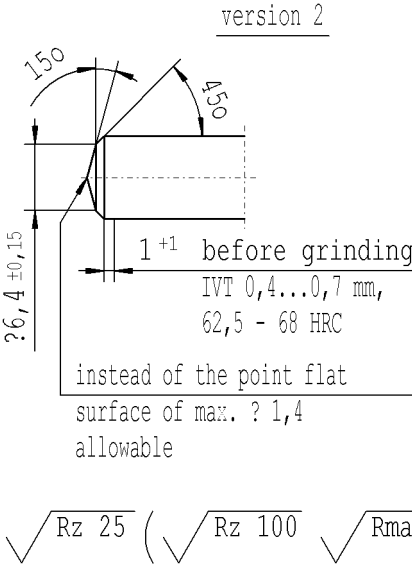
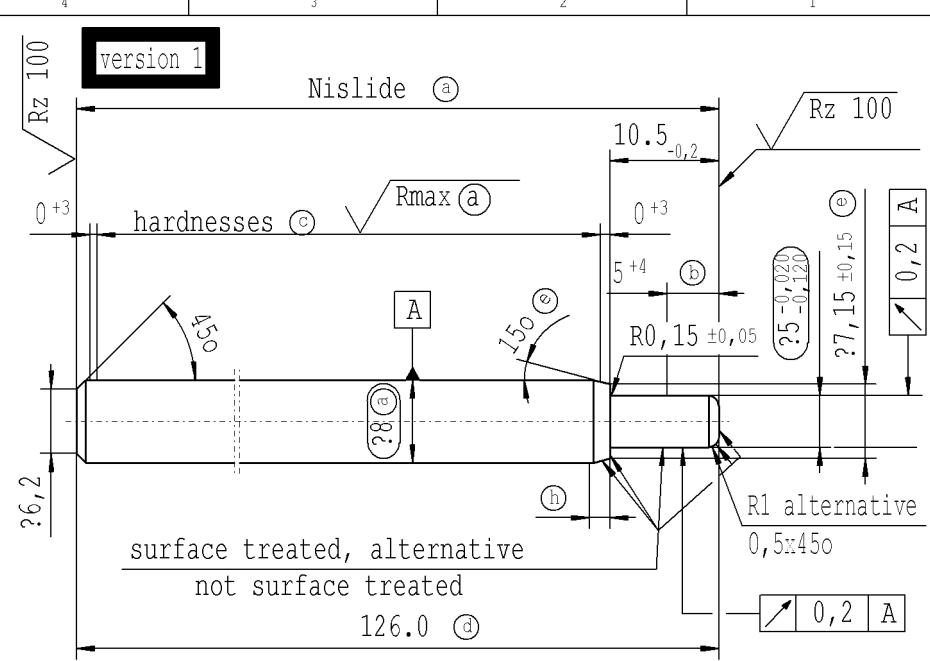


Ident. Doc.: SN 53.11#04039#max. 22/10/2015 - 817

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			
1	3383AH						93.0	10.5	1
2	727547						342.0	10.5	1
3	4180AV					4180AV	537.0	10.5	1
4	511733						222.0	10.5	1
5	331918				331918		219.0	10.5	1
6	365602						96.0	10.5	1
7	8093AP						156.0	10.5	1
9	5598AU			0697SN			114.0	10.5	1
10	3776BN						69.0	10.5	1
11	316156						255.0	10.5	1
12	116343				116343		260.0	10.5	1
13	868289						168.0	10.5	1
15	316202				316202		132.0	10.5	1
16	4754BA			3073RN	4754BA		222.0	10.5	1
17	766828				766828		197.0	10.5	1
19	243124				243124		171.0	10.5	1
21	367990						126.0	10.5	1
22	548243						162.0	10.5	1
23	273350				273350		162.0	10.5	1
26	6705BJ			7553NB	6705BJ		243.0	10.5	1
29	8057LQ				8057LQ		363.0	10.5	1
30	3219CL						195.0	11.5	1
32	276952			3103RV	276952		258.0	10.5	1
33	339199				339199		123.0	10.5	1
35	7967CS				7967CS		336.0	10.5	1
37	268275				268275		357.0	10.5	1
38	306207						177.0	10.5	1
40	305340						315.0	10.5	1
41	7317DF						369.0	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 $\leq 1,5 \mu m$
- (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/nislanding
- (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

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

sheet 1
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	0,5x45o alternative R1	R1 alternative 0,5x45o	chrome DOK 1021401	Tab.XVI	Material: mat.no. 010731				
old	-	Tab4	0,5x45o	0,5x45o alternative R1	-	-	All dimensions are in mm				
Field	D-E/1-3	Pos.261	D-E/1	D-E/1	Pos 78;90;115;137;185	-	Identification of important characteristics				
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	Scale: (Original DIN A3) 2:1				
Chg. No.	550622	553536	565550	571413	615932	629279	Dimensions without tolerances DIN ISO 2768-mK				
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							Document No.: 10003762				
							Material No.:				
							STABILUS PISTON ROD				