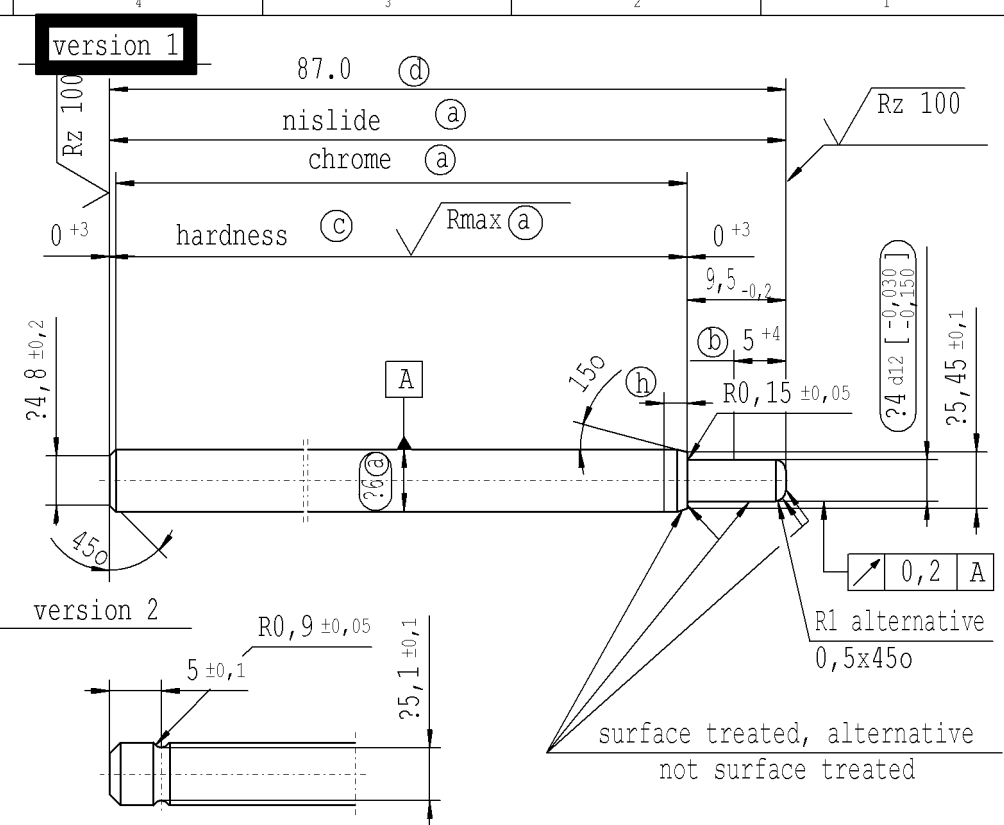


Ident. Doc.: SN 53.11#06#00#max. 24/7/2014 - 9:4

supp. No.	material no.				A	B	
	table I chromed	table IV Nislide black	table VIII Nislide black	only STU5/STMX table X Nislide 'G'			KOST without surface treatment
39		335185		335185		138.0	1
40	476129	338354		338354	8435WU	99.0	1
41		360872		360872		135.0	1
42		363855		363855	453863	123.0	1
43		5327GD		5327GD		134.5	1
44	465445	9886BG		9886BG	8436WP	93	1
45			5127HN			219.0	1
46		5213IB		5213IB		54.0	1
47		477451		477451		156.0	1
49		486388	9161WI	486388	525084	141.0	1
50		486574		486574		126.0	1
51		541982		541982	523889	198.0	1
52		488712		488712	524845	159.0	1
53		8654LQ		8654LQ		83.0	1
54		493759		493759	453385	102.0	1
55		549061		549061	523650	210.0	1
56		511897		511897	330962	132.0	1
58		532681		532681	524606	129.0	1
61		1556WZ		1556WZ		131.0	1
62		619248		619248	504530	150.0	1
63			5104IJ			273.0	1
65		594032		594032	445941	78.0	1
66		4245LX		4245LX		162.0	1
67		7972KF		7972KF		153.0	1
68		577502		577502		87.0	1
69		580643		580643		114.0	1
72		2451NE		2451NE		165.0	1
76		1863PO	6277NZ	1863PO	453146	204.0	1
77		823023		823023		63.0	1



- (a) piston rod processing per STAB-Spec. 10006248
for piston rods without surface treatment
grinding dimension $^{+0.040}_{-0.051}$
Rmax after grinding $\leq 1,5 \mu\text{m}$
- (b) surface chrome-free
- (c) RHT 0,4..0,7 mm before grinding
 ≥ 68 HRA (per DIN ISO 6508)
- (d) tolerance $^{+0,2}_{-0,1}$ after turning
 $^{+0,2}_{-0,1}$ after straightening
 $^{+0,2}_{-0,1}$ after chroming/nisliding
- (h) chrome-free max.2 mm qualified
layer thickness, no test range

* only Tab. IV

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

sheet 2 of 4

AIAG CQI-standards acc. to STAB-Spec. 10027692						
DE: X	EN: X	ES:	IT:	PR:	FR:	RO:
new	grinding dimension		frame	surface treated ...	R1 alternative 0,5x45o	Tab.IV + X / only STU5/STMX text removed pay part China
old	-	-	-	-	0,5x45o	Tab.IV
Field	-	-	-	C-D/1-2	D/1	Tab.
Date/Name	16.11.2005 Geisbüsch	07.03.2006 Geisbüsch	16.05.2006 Sch7nberger	04.02.2009 Hein	30.10.2012 Kron	19.03.2014 Hein
Chg. No.	546908	549233	550620	571062	600302	611695
Rev.	22	23	24	25	26	27

Material:		Environmental protection acc. to STAB-Spec. 10005649	
mat.no. 010707	Identification of important characteristics	All dimensions are in mm	Date Name
Edge tolerances acc. to DIN ISO 13715	Dimensions without tolerances DIN ISO 2768 mK	Scale: (Original DIN A3) 2:1	Drawn by 20.05.1992 Kirsch
Surface finish DIN EN ISO 1302	We reserve all rights to this document, to any patents or patent registrations related hereto, and to the duplication, retransmission by third parties and misc. use. Any use of this document is not permitted without the written consent of STABILUS.	Checked 19.03.2014 Klinkner	
Replaces:		Document No.: 10003697	
STABILUS	PISTON ROD	Material No.:	