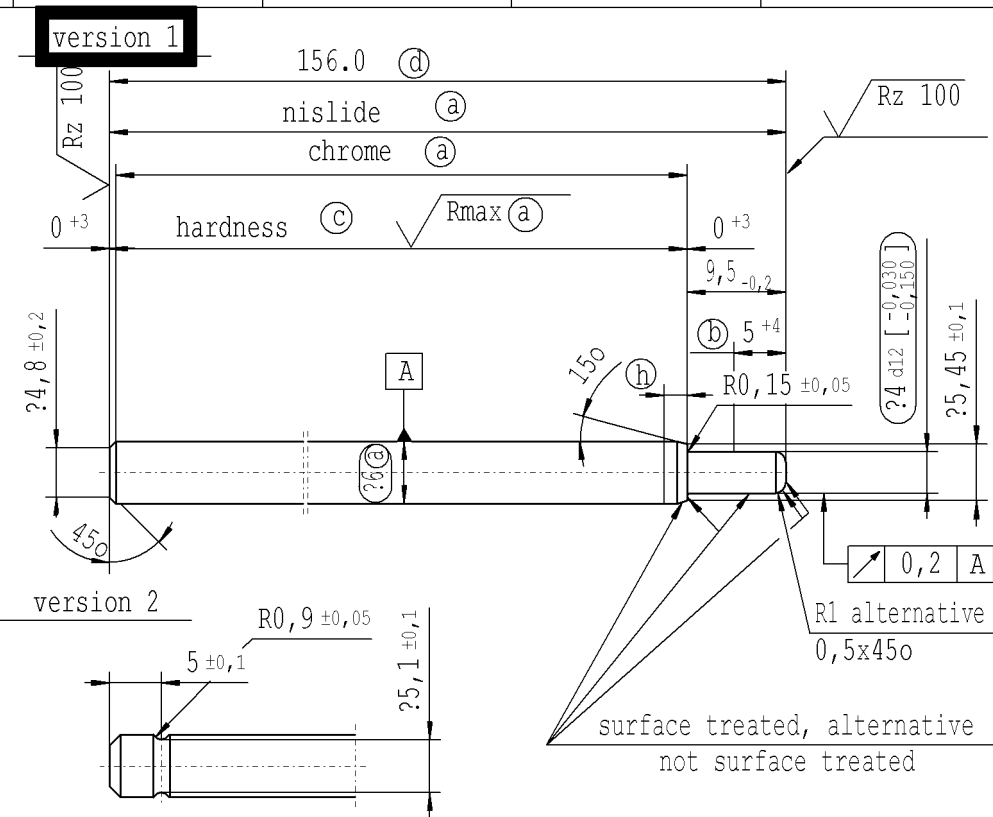


Ident. Doc.: SN 53.11#06#00#max. 24/7/2014 - 9:4

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		5213TR		5213TR		54.0	1
47		477451		477451		156.0	1
49		486388	9161W1	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
 $\geq 68 \text{ HRA}$ (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

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

sheet 2 of 4

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		
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: mat.no. 010707

Surface finish DIN EN ISO 1302

Replaces:

STABILUS

PISTON ROD

Material No.: 10003697

Document No.: 10003697

Scale: (Original DIN A3) 2:1

Identification of important characteristics

Dimensions without tolerances DIN ISO 2768 mK

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Drawn by: Kirschn
Checked: Klinkner
Date: 20.05.1992
19.03.2014