

WORKS STANDARD

class table of characteristics

!Schutzvermerk nach DIN ISO 16016 beachten!

AL-KO
AL-KO DÄMPFUNGSTECHNIK GMBH
09661 Rossau

designation PISTON ROD K 14	classification-no. D421672	finely classification PISTON ROD for GF14	created by:Rilk Datum:28.03.07	sheet 1	format A3	WN-Katalog	Register
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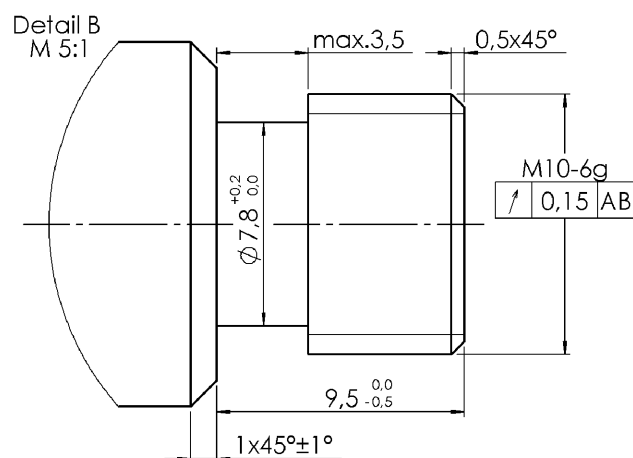
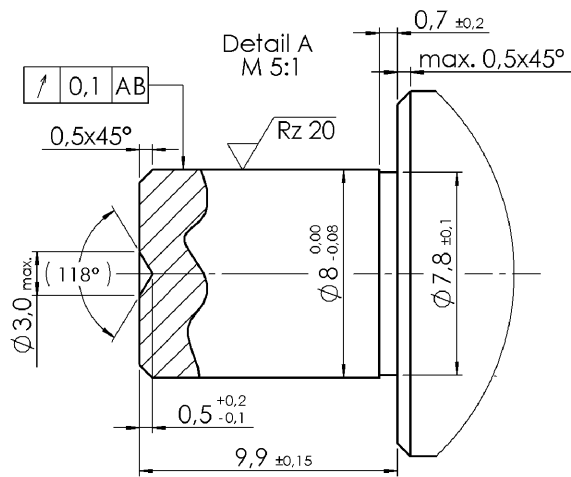
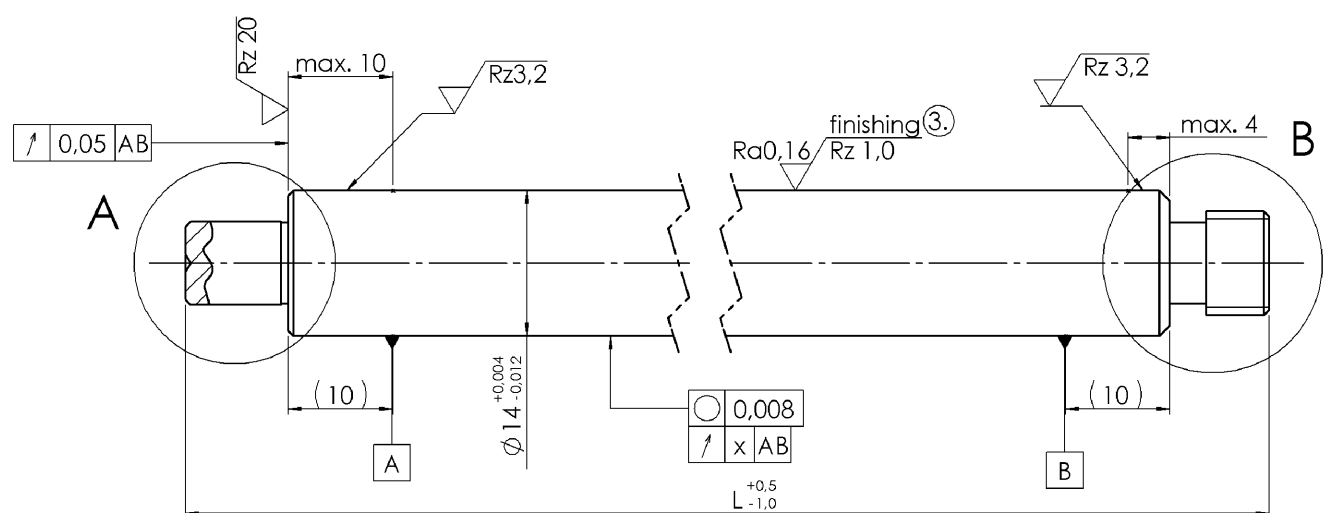


table No.1

length of piston rod L	dimension x
up to 150	0,1
over 150 up to 200	0,15
over 200 up to 250	0,2
over 250 up to 300	0,25
over 300	0,3



- material: rod EN 10278 - 14,3h9 EN10277-2 - C35 (1.0501)
crack depth max. 0,15; base size Ø14,3 h9
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- tolerance acc. DIN ISO 2768-m
- material percentage contact area $M_f = 50 - 70\%$
- measured at cutting depth $c = 0,5 \cdot R_z$ and reference line $c_{ref} = 0\%$
- surface protection:
- salt bath nitriding (thickness 15 µm minimum)
- finishing
- corrosion resistance:
- minimum 144hrs salt spray test (NSS-test) according DIN EN ISO 9227
- validation according DIN EN ISO 10289 degree of protection $R_p = 10$
- accuracy class of screw thread after nitriding: acceptable up to 6h
- horizontal displacement/ concentricity (dimension x): see table No.1
- designation of a piston rod, execution "K", nominal size-Ø 14mm, length L=100mm:

PISTON ROD K14x100

material-no.	issue	mod.-No.	modification text	date	name

Kenn- buch- stabe		Revs	A	B	C	D	E	F
			length L	designation	note	date	name	Tab
Benen- nung	material-no.			PISTON ROD				
Einheit POS								
01	673245	a	247	PISTON ROD K 14 X247		16.06.15	Rilk	\$
02	673246	a	297	PISTON ROD K 14 X297		16.06.15	Rilk	\$
03	673247	a	347	PISTON ROD K 14X347		16.06.15	Rilk	\$
04	673248	a	397	PISTON ROD K 14 X397		16.06.15	Rilk	\$
05	673249	a	447	PISTON ROD K 14 X447		16.06.15	Rilk	\$
06	673250	a	497	PISTON ROD K 14 X497		16.06.15	Rilk	\$
07	673251	a	547	PISTON ROD K 14 X547		16.06.15	Rilk	\$
08	673252	a	147	PISTON ROD K 14 X147		16.06.15	Rilk	\$
09	673253	a	197	PISTON ROD K 14 X197		16.06.15	Rilk	\$
10	673254	a	322	PISTON ROD K 14 X322		16.06.15	Rilk	\$
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ausgegeben von: SCHÜßLER 18.06.2015 13:30:35

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