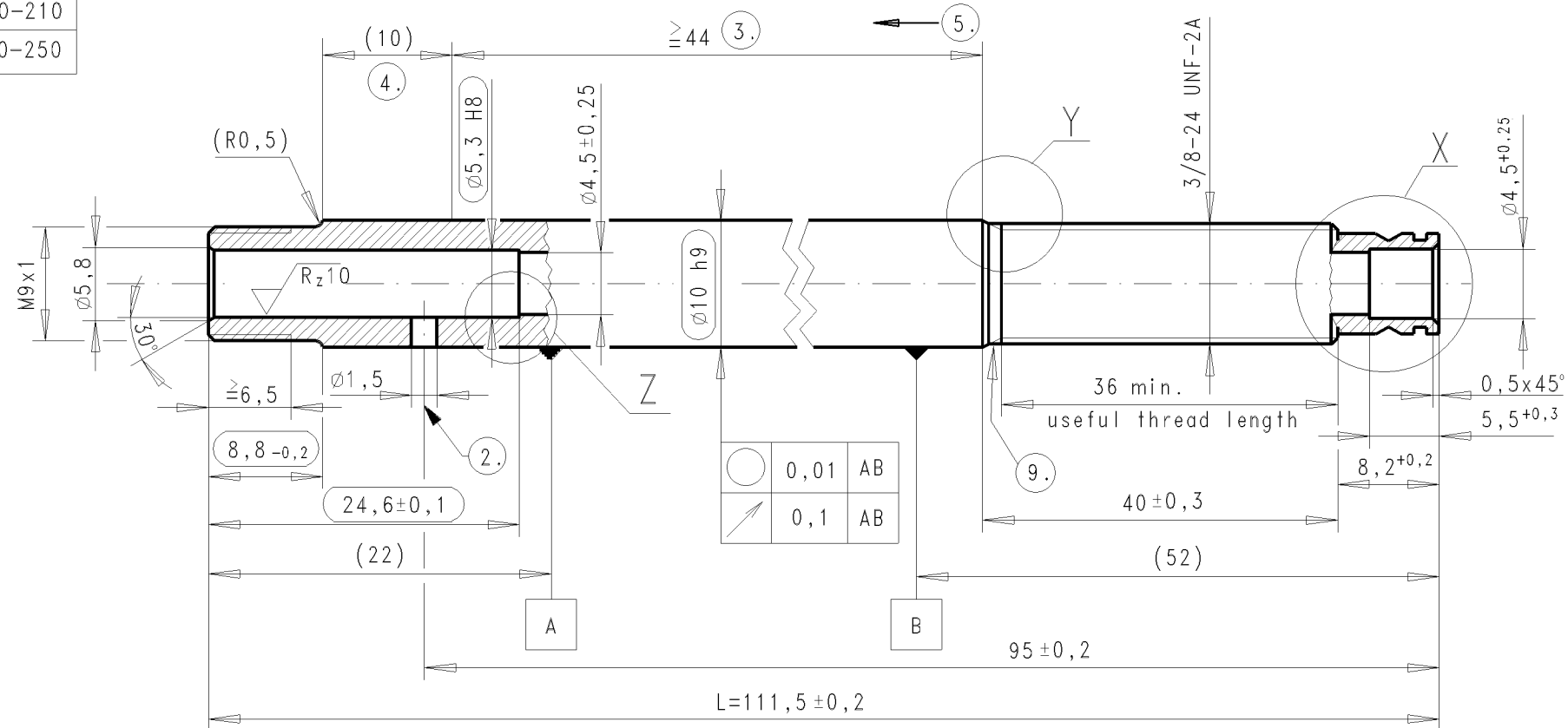
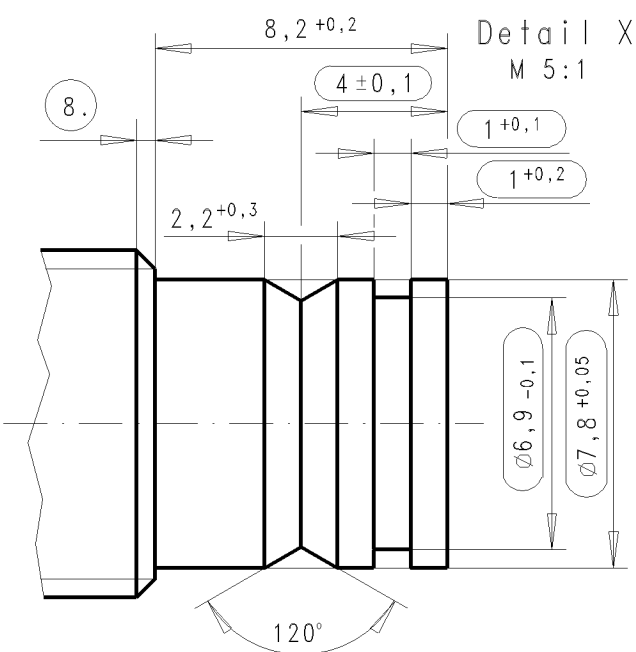
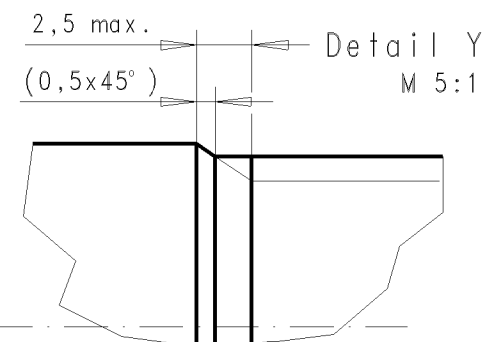
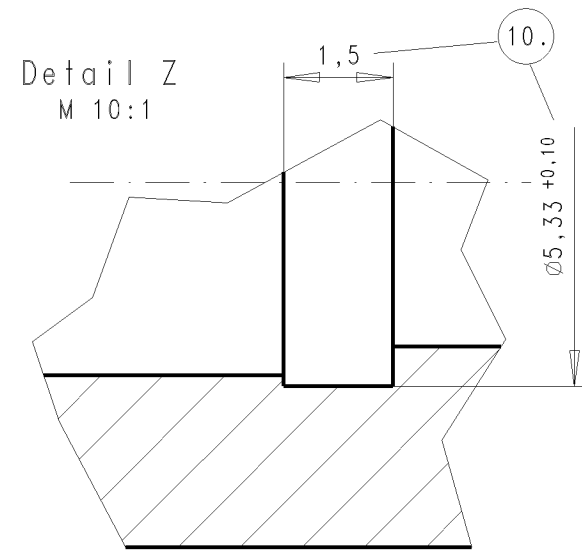


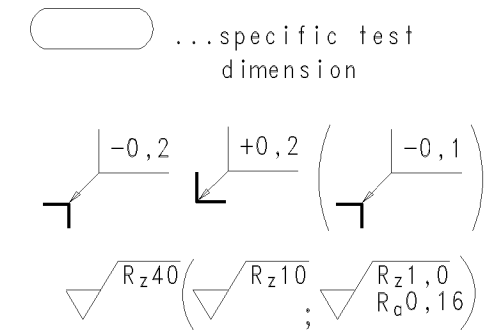
Schutzvermerk nach DIN 34 beachten  
Alle Rechte bei AL-KO, auch für Schutzrechtsmeldungen. Alle Verfügungsbefugnisse, wie Kopie- und Weitergaberecht, bei uns.

10 h9	0 -0,036
5,3 H8	+0,018 0
toleranced dimension	limit of tolerance

current lengths of piston rod L	80-210
favoured lengths of piston rod L	70-250



10. dimensions are technological values
9. centre point respectively drill bit: need for subsequent colour coding; in line with cross-hole (diameter circa 1mm; depth 0,5mm maximum)
8. bezel before thread chasing: 45° start at diameter 7,8 (+0,05) with distance 8,2 (+0,2); bezel caused by production is not dimensioned; authoritative is free movement of the thread ring gauge
7. material: tube 10,3x2,9 E355+C or C45E+C DIN EN 10305-1 tensile strength minimum 640 MPa
6. accuracy class of screw thread after nitriding: acceptable up to 6h
5. work flow direction at grinding and finishing; edge free from burrs



4.  $\sqrt{Rz3,2}$  unfinished acceptable
3.  $\sqrt{Rz1,0}$  finishing  
 $Ra0,16$
- material percentage contact area  $M_r=50-70\%$ ; measured at cutting depth  $c = 0,5 \times R_z$  and reference line  $c_{ref.} = 0\%$
2. manufacturing of drill hole  $\varnothing 1,5$ : no burr on bored  $\varnothing 5,3$  H8 in axial direction; acceptable burr at drilling outlet in radial direction:  $-0,1$
1. surface protection:
  - salt bath nitriding (thickness  $15\mu m$  minimum)
  - finishing
 corrosion resistance:
  - minimum 144 hrs salt spray test (NSS-test) according DIN EN ISO 9227
  - validation according DIN EN ISO 10289
  - degree of protection  $R_p=10$

a new drawing		Werkstoff NORM		Holzzeug NORM		Material-Nr.	
Rev	Änderungstext	see point 7		see point 7			
Oberfläche n. DIN ISO 1302		zul. Abweichung n. DIN ISO 2768		Gewicht kg		Maßstab 2:1 (5:1; 10:1) Format A3	
m				2015 Datum Name		DN E673585	
				Benennung		Bl.-Nr.	
				PISTON ROD		1	
				S10x111,5		1	
				AL KO		Bl.-Anz	
				DAMPFUNGSTECHNIK GMBH		Material-Nr.	
						673585	
						Klass.-Nr.	
						*	
a	30.10.15	Mie					
Rev	Änd.-Nr	Datum	Name	Urspr	Ers. f	Ers. d	