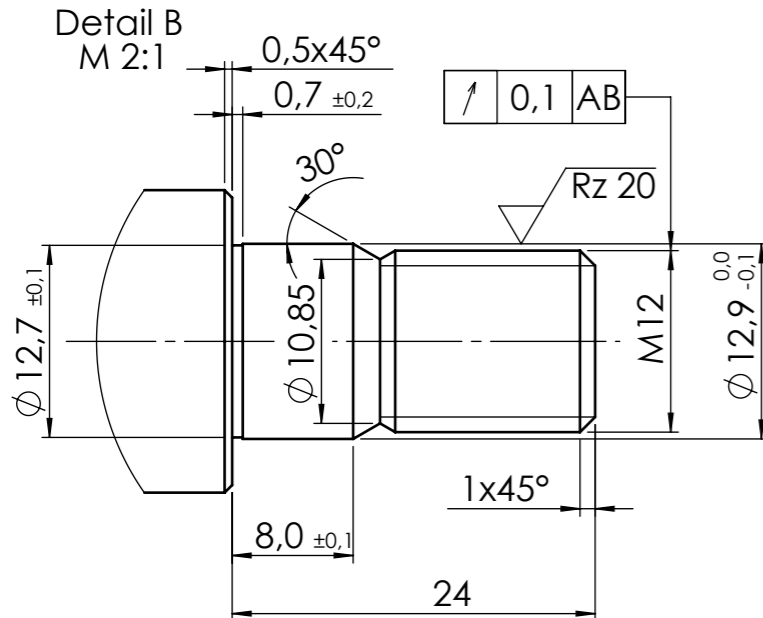
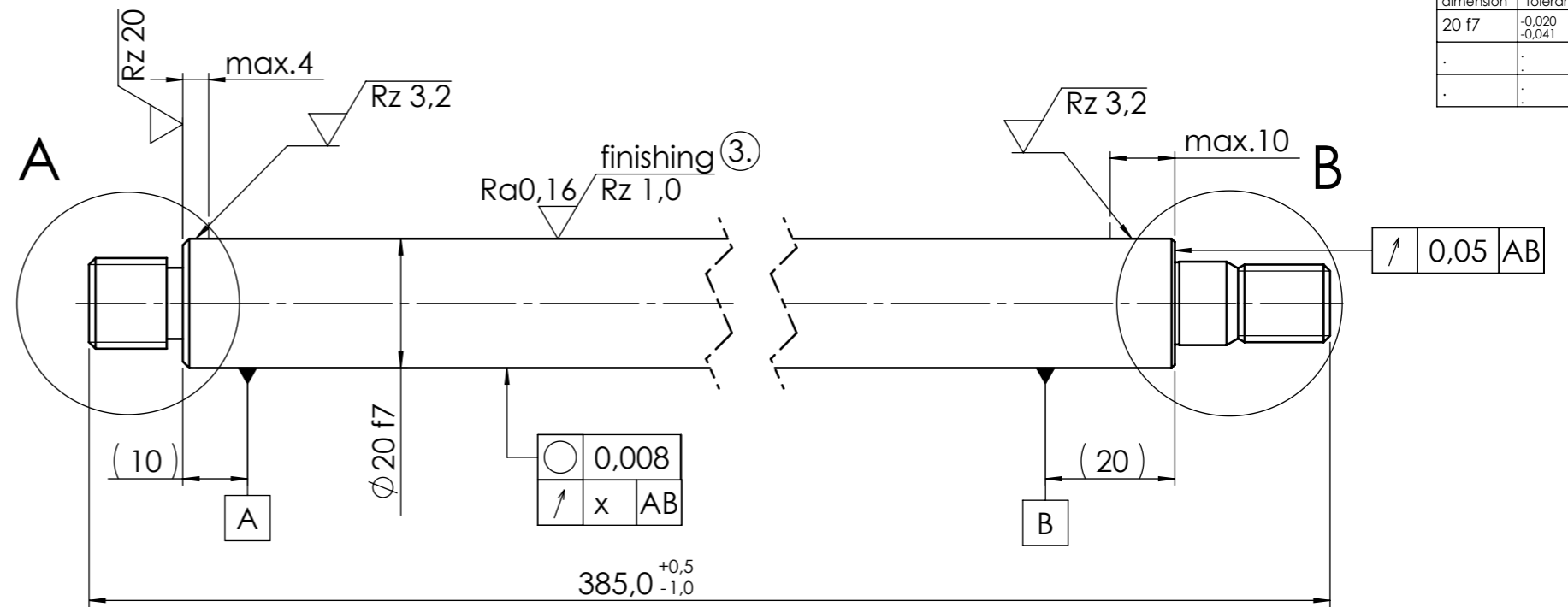
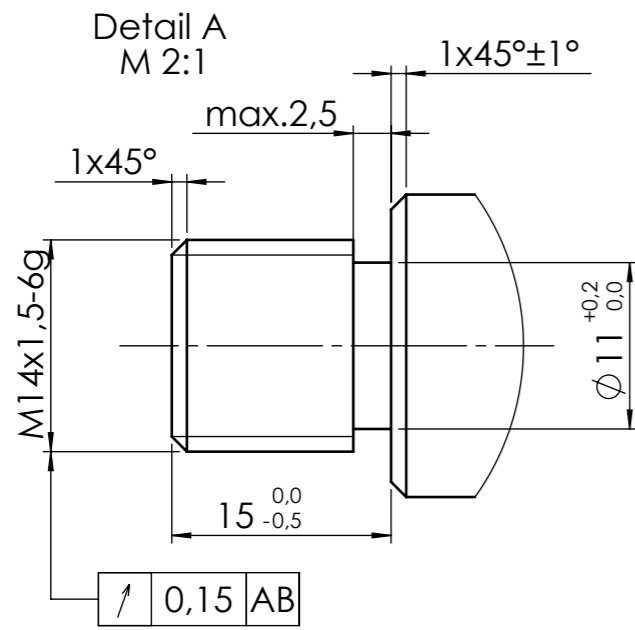


toleranced dimension	limit of tolerance
20 f7	-0,020 -0,041
.	.
.	.



- material: rod C45 (1.0503 acc. EN10083-2), EN10277-2; 20,3h9 EN 10278
crack depth max 0,08
-
- material percentage contact area $M_r = 50 - 70\%$
- 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 144 hrs 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 Nr.1

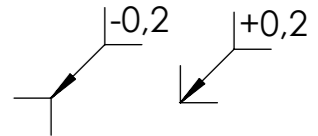


table Nr.1

length of piston rod L	dimension x
up to 150	0,10
over 150 up to 200	0,15
over 200 up to 250	0,20
over 250 up to 300	0,25
over 300	0,30

table Nr.2

current lengths of piston rod L	135 - 685
favoured lengths of piston rod L	100 - 800

PDM-Status:

Vers.Issue		Modification Text		surface acc. EN ISO 1302		tolerance acc. DIN ISO 2768 m		material standard SEE TEXT INDICATION		Raw Material Standard		Material-No.	
Vers.Issue	Mod.-No.	Date	Name	weight	0,083 KG	created by:	RILK	Date:	28.01.2015	Project:			
Description										PISTON ROD T20X385			
				AL-KO		Material-No. 673588		Class.-No.					
				AL-KO DÄMPFUNGSTECHNIK 09661 Rossau		Scale 1:1		Sh.-No. 2		No. of Sh. 2		Format A3	
Origin				Repl. for				Repl. by					