

1. material: rod EN 10278 - 8,3h9 EN10277-2 - C35 (1.0501)
crack depth max. 0,15; base size Ø8,3 h9
2. material percentage contact area $M_r = 50 - 70\%$
- measured at cutting depth $c = 0,5 \cdot R_z$ and reference line $c_{ref} = 0\%$
3. surface protection:
- salt bath nitriding (thickness 15 μm minimum)
- finishing
4. corrosion resistance:
- minimum 144hrs salt spray test (NSS-test) according DIN EN ISO 9227
- validation according DIN EN ISO 10289 degree of protection $R_p = 10$
5. accuracy class of screw thread after nitriding: acceptable up to 6h
6. horizontal displacement/ concentricity (dimension x): see table Nr.1
7. use cutting insert with corner radius 0,2mm
8. shear-plane for projection welding
9. useful thread length 7,5mm (thread gauge)

execution	nominal dimension d1	d3	L3	L4	L5	α
tolerance	+0,004 -0,012		0 -0,5	+1 0	$\pm 0,3$	+15° 0
RA	7,92	M6	21,5	8,5	2	15°

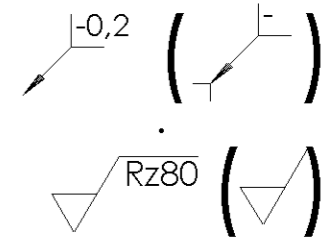


table Nr.1

test length $L_p = L_1 - (L_3 + 25)$	dimension X
up to 150	0,08
over 150 up to 200	0,15
over 200 up to 250	0,20
over 250	0,25

...specific test dimension

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 KG		created by: RILK		Date: 02.06.2015	
										Description		Project: -	
												PISTON ROD RA 7,9X163,5	
												Material-No. 673258	
												Class.-No. -	
												Scale: 2:1	
												Sh.-No. 1	
												No. of Sh. 1	
												Format A3	
Origin -												Repl. by -	