

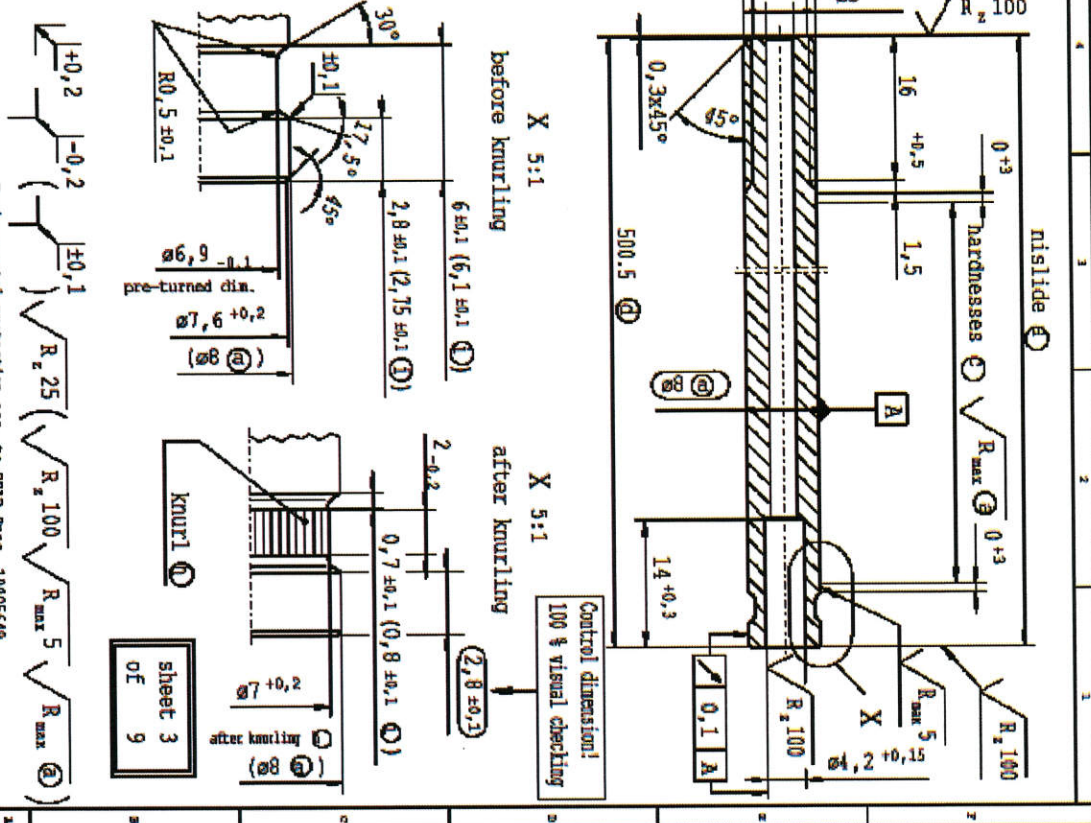
suppl. No.	material no.	surface treatment processing acc. to spec-spec. 10005648			overall length	threads-length thread-out-bar
		code IV slide block	code VIII slide block	code V slide block		
71				9691GT	143.5	40
75				344ZEI	215.5	16
77	9405YM				491.5	16
79				9926IH	182.5	16
80				9942IP	410.5	16
81				0165KA	350.5	16
82				4817KU	110.0	13
83				0777LT	263.5	16
84				0295VA	96.5	16
86	5192MD	5624MA		500.5	16	
88				9283MT	326.3	16
89				1053PW	359.5	16
90				3352RJ	74.5	16
93				6397SN	317.5	16
94				4025TR	63.0	16
95				4687TK	173.5	16
96				8606DA	85.0	22
97				1005VS	110.5	20
98				6833VM	470.5	16
99				5685VE	131.5	16
100				7769VA	365.5	16

- ① piston rod processing per spec-spec. 10005648
- ② RRF 0.4..0.7 mm before grinding
- ③ 65 BBA (per DIN ISO 6509)
- ④ tolerance:
 - m1: before thread-rolling
 - m2: after thread-rolling
 - m3: after straightening
 - m4: after distorting
- ⑤ chamf. before grinding for piston rods a 0.15 -0.11
- ⑥ threaded stud pre-turned diam. ø7.30 -0.06
- ⑦ thread roll tolerance 6e
- ⑧ thread tolerance acc. DIN ISO 965-3
- ⑨ chamf-profile manufactured with knurl roll DIN 82 - BBA 0,5

Temporary additional inspection 014/01
Only apply to
100% visual check for cleanliness of through hole
Not apply to Tab.X

Temporary additional inspection 008/13
valid only for v7 marked Material No.
100% Check concentricity thread M8x1
Test equipment roll cradle with dial gauge
Caution using flat peak measuring!
Concentricity tolerance:
acc. to DIN ISO 2768-mk > max. 0.2 mm

Part. No. 010146	Mat. No. 010146
Fig. tolerance per DIN ISO 2768	Fig. tolerance per DIN ISO 2768
Technical file DIN 91 20 1202	Technical file DIN 91 20 1202
Inspection: per ET/20A	Inspection: per ET/20A
Dimensional protection acc. to SRM-Spec. 10005648	Dimensional protection acc. to SRM-Spec. 10005648
Material: M8x1	Material: M8x1
Doc. No. 10004290	Doc. No. 10004290
Issue: 30.01.2015	Issue: 30.01.2015
Drawn by: [Name]	Drawn by: [Name]
Checked by: [Name]	Checked by: [Name]



QTY: 5,000 / month

STABILUS PISTON ROD