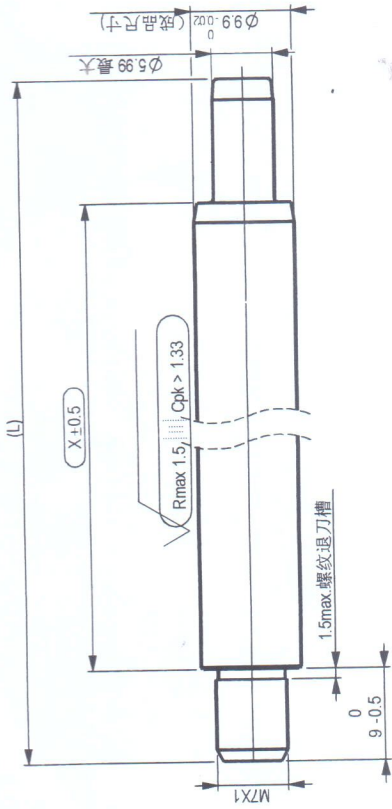
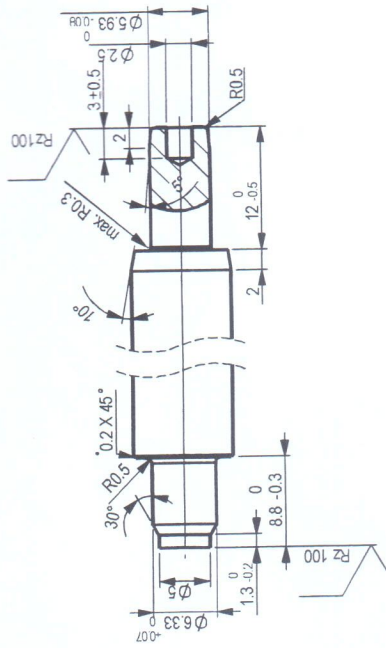


Rz 25

# 受控 Control

预加工尺寸



发放部门(代号) of-H  
Distributing Department(NO.)  
发放日期 2016-11-22  
Distributing Date

技术要求:

1. 材料45钢 GB/T 699
  2. 校正后X尺寸区域直线度小于X×0.002
  3. 活塞杆表面黑色氧化渗氮处理, 渗氮复合层最小厚度12μm
- 硬度HV0.05=500, 要求满足DIN EN ISO 9227 NSS 144小时无锈蚀。

Kennz.: VA 04 03

- = Kontrollmaß / inspection dimension
- ( ) = Hilfsmaß / auxiliary dimension
- [ ] = Vorbearbeitungsmaß / pre-work dim.

**SUSPA**

Ersetzt durch  
replaced by

Ersetzt für  
replacement for

Werkstoff /  
material

Datum /  
date

Name

Bezeichnung /  
name

21 11 16  
21/11/16

TXL

ISO 728

2:1

活塞杆/Piston rod

051 1157

12

1/2

Index	Version	Date	approved by	symbol	更改标识	更改单号	更改内容
Index	Version	Date	approved by	symbol	更改标识	更改单号	更改内容
12	TXL	2016.11.21	Kshen	0	0	ECN-AA-PE-1011	螺纹端增加0.2x45°倒角
11	TXL	2016.09.28	Kshen	0	0	ECN-AA-PE-996	图纸和Lis分开, 取消硬化区域要求
10	FYX	2016.08.03	kshen	0	0	ECN-AA-PE-956	新增零件号 051 80043 X=227.5 add new part no.051 80043 x=227.5
09	wxy	2015.07.23	kshen	0	0	ECN-AA-PE-825	新增零件号 051 80016 X=334.5 add new part No.051 80016 x=331.5 add new part no.051 80016 X=334.5 add new part No.051 80016 x=331.5
08	zhz	2013.05.31	kshen	0	0	ECN-AA-PE-604	新增零件号 051 11381 X=177.5 add new part no.051 11381 X=177.5
07	ZHZ	2011.08.12	mhuang	0	0	ECN-AA-PE-462	新增零件号 051 11381 X=223 add new part no.051 11381 X=223
06	mhuang	2011.05.17	dzhou	0	0	ECN-AA-PE-441	盐雾试验要求改为144小时/ salt spray test requirement changed to 144hrs
05	yqzhang	2010.12.23	Wsong	0	0	ECN-AA-PE-402	新增零件号 051 11381 X=236.5 add new part no.051 11381 X=236.5 add new part no.051 11381 X=236.5
04	fwrian	2010.06.24	mhuang	0	0	ECN-AA-PE-352	新增零件号 051 11373 X=297 add new part no.051 11373 X=297
03	mhuang	2009.11.24	mhuang	0	0	ECN-AA-PE-270	取消倒角(cancel the chamfer)
02	fwrian	2009.10.20	mhuang	0	0	ECN-AA-PE-248	新增零件号 051 11372 X=188.5 add new part no.051 11372 X=188.5
01	mhuang	2009.03.19	Wsong	0	0	ECN-AA-PE-173	表面硬度改为HV0.05 ≥ 500 surface hardness changed to HV0.05 ≥ 500
版本号	编制	日期	认可	更改标识	更改单号	更改内容	
Index	Issuer	Date	approved by	symbol	更改单号	更改内容	

更改记录/change record

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Metrisch  
Maßangaben in Millimetern  
Dimensions shown in millimeters

Werkstätten, wenn nicht anders angegeben  
DIN ISO 13715 Außenkonturkanten  
Rz 25  
Rz 6.3  
Rz 1.6  
Rz 0.8  
Rz 0.4  
Rz 0.2