



- material : round bar C45 (1.0503 according to EN10083-2), EN10277-2; 10,3 EN 10278
crack depth max. 0,15; reference-Ø10,3
- $\sqrt{\text{Rz 80}}$, $\sqrt{\text{Rz 10}}$, $\sqrt{\text{Rz 3,2}}$, $\sqrt{\text{Rz 1}}$
- roughness on semi-finished product before nitriding Rz < 0,8
contact ratio m = 50-70%
measured at cutting depth c = 0,5 Rz and reference line c = 0%
- surface treatment : - salt bath nitriding according to QPQ-method
- composite layer thickness : 12⁺¹⁰ μ
- pore zone : 2 - 5 μ
(max. 30% of composite layer thickness)
- surface-hardness : ≥430 HV 0,1 DIN EN ISO 6507-1
- corrosion resistance : - min. 96h salt spray test according to DIN EN ISO 9227
NSS-test according to DIN EN ISO 9227
- evaluation according to DIN EN ISO 10289,
protection grade Rp 10
except for threaded studs
- accuracy class of threads after treatment up to 8h acceptable
- position deviation of dimension, (concentric running, concentricity and straightness) see table

position deviation table

rod length	dimension "X"
< 150	0,10
150 bis 200	0,15
200 bis 250	0,20
250 bis 300	0,25
> 300	0,30

(dimensions in mm)

rod length	Index
150	M45007
250	M45008
300	M45009
350	M45010

TOLERANCJE WYMIARÓW NIETOLEROWANYCH WG: Workpiece edges DIN 6784 general tolerances ISO 2768-m	MATERIAL:		This drawing is exclusively our property. It may not be disclosed to third parties or used in any other way without our consent.	METODA RZUTOWANIA		Intelli CAD	
	WYKONAŁ	IMIE I NAZWISKO		DATA	CHARAKT. SPECJALNE		NAZWA: Piston rod
	ZATWERDZIŁ	L.Swiątek		14.05.2018			
	FORMAT:	A3		MASA:	NR RYSUNKU: KE-KOSTABE-C45-0,036-M10x1x18		ARK./ARK-Y 1/1
PODZIAŁKA:	1:1	FA Krosno			NR INDEKSU wg. tabeli		