

Color: brown/black

1.) Bond zone: = 12 +10 µm

2.) Porous zone: 2-8 µm

Surface treatment

Surface processing of piston rods < 800mm length according to QPQP

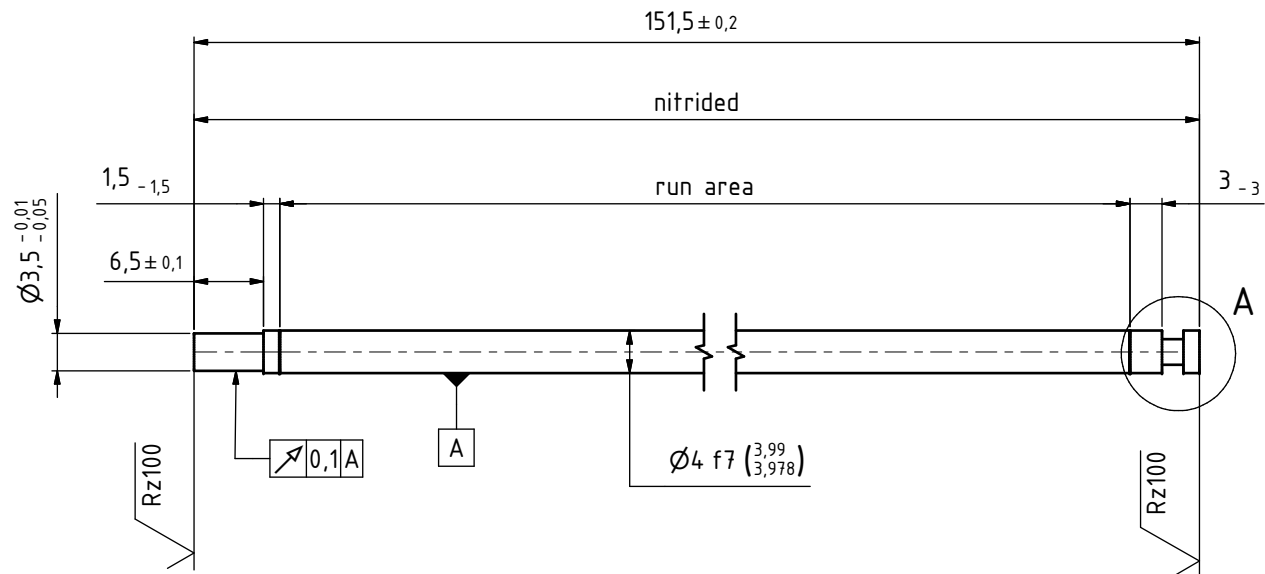
- process Surface hardness HV 0,1 DIN EN ISO 6507-1

Corrosion resistance: 144 h NSS DIN EN ISO 9227

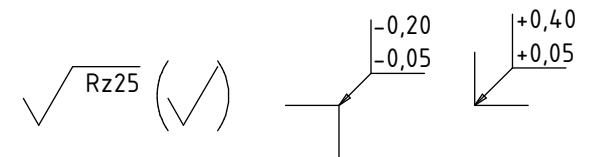
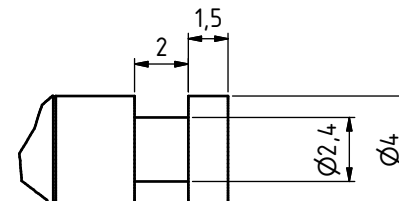
Piston rod free from cracks,

guaranteed by optical individual test or eddy current test

Finished dimension [mm]			roughness depth after final condition	
permissible runout			run area	no run area
X	l1	l	$R_a = 0,06 - 0,1 \mu m$ $R_z \leq 0,90 \mu m$	$R_a \leq 0,20 \mu m$ $R_z \leq 1,5 \mu m$
0,05	50	>55		
0,10	100	>105		
0,20	150	>155		
0,30	225	>230		



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								Material: Weight:							
						Date	Name	Kolbenstange KST Ø4 Nz3,5x6,5 St L=151,5 Description:							
						Drawn by	28.11.2018						UGneiting		
						Checked									
						Norm									
									KST__-S-00243-E1					1	
														A3	
						 HAHN GASFEDERN									
A	STAB Normen für Oberflächte hinzu: Material geändert			28.11.18		UGneiting									
Rev.	Modification			Date		Name		Replaced by:		Replacement for:				MOD-Nr.: KST -S-00243-EM	