

Color: brown/black

1.) Bond zone: = 12 +10 µm

2.) Porous zone: 2-8 µm

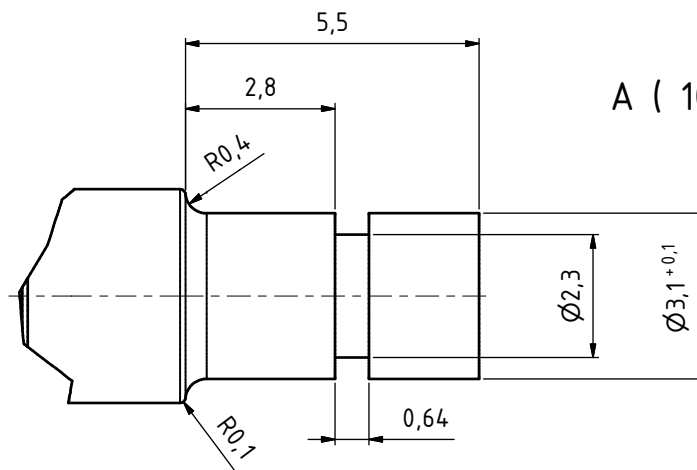
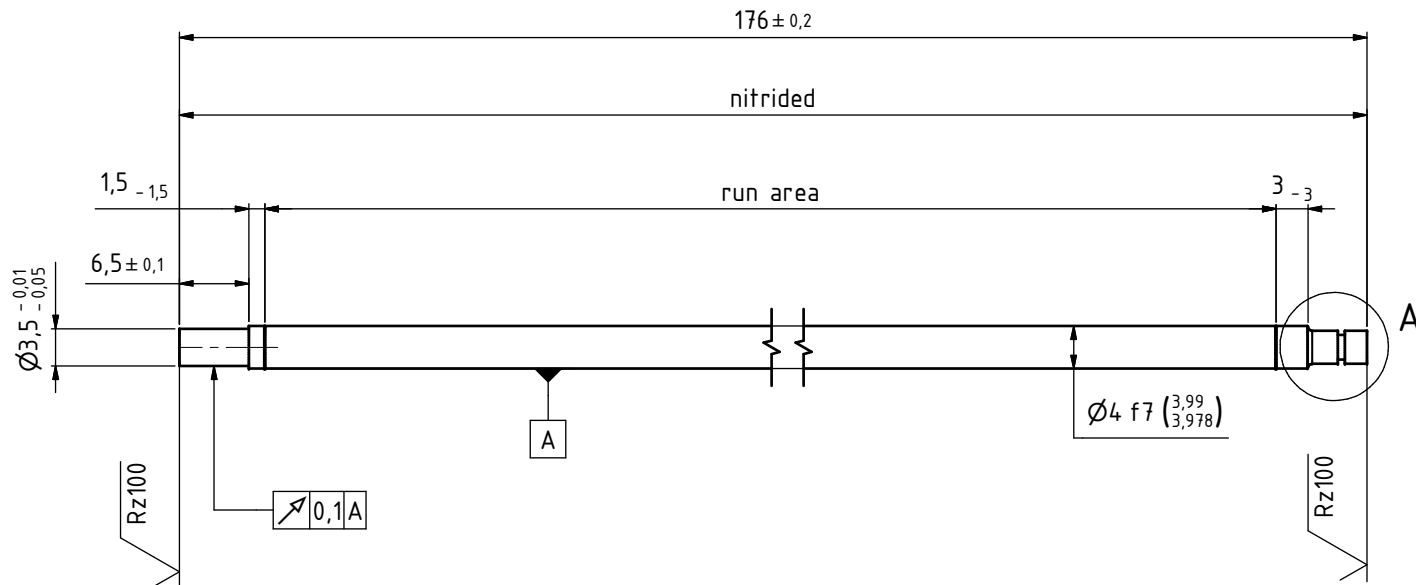
Surface treatment

Surface processing of piston rods < 800mm length according to QPQP
- process Surface hardness HV 0,1 DIN EN ISO 6507-1

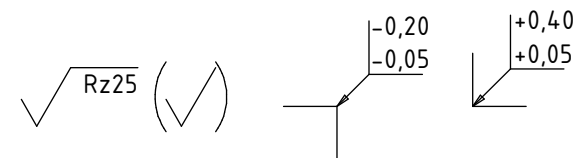
Corrosion resistance: 144 h NSS DIN EN ISO 9227

Piston rod free from cracks,

guaranteed by optical individual test or eddy current test



A (10 : 1)



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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Date				Name	UGneifing	Material:		
Drawn by				28.11.2018	UGneifing	Weight: -		
Checked						Kolbenstange		
Norm						KST Ø4 Nz3,5x6,5 L=176		
Description:				KST_-S-00272-E1			1	
Rev				Modification	Date	Name	Replaced by:	Replacement for: ENG-004235 MOD-Nr.: KST_-S-00272-EM

