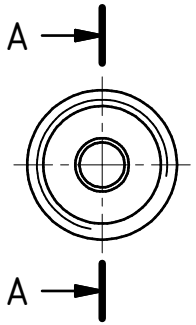
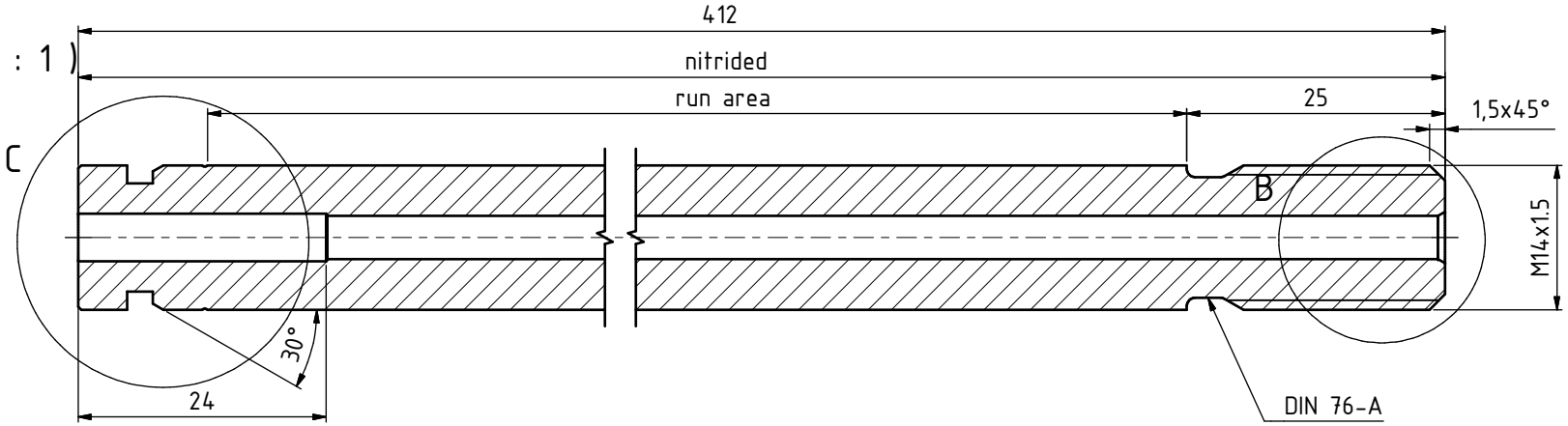
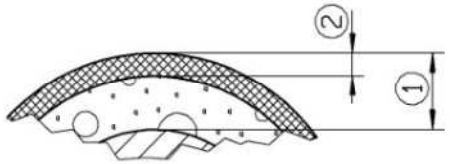


A-A (2 : 1)



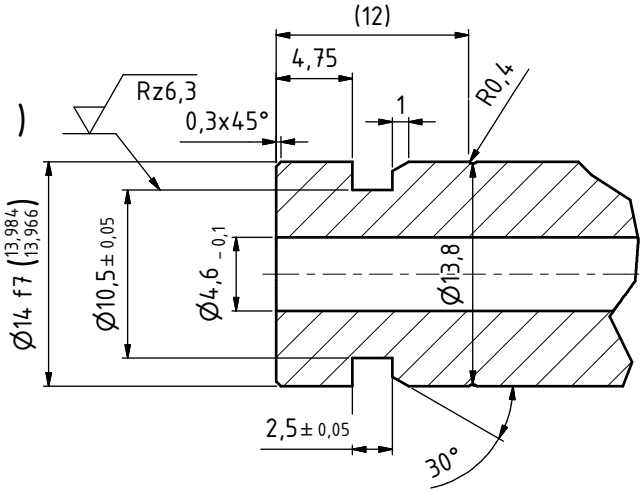


Color: brown/black
1.) Bond zone: = 12 +10 µm
2.) Porous zone: 2-8 µm

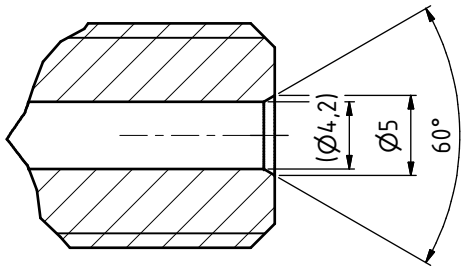
Surface treatment
Surface processing of piston rods < 800mm length according to QPQP
- process Surface hardness ≥ 430 HV 0,1 DIN EN ISO 6507-1
Corrosion resitance: 144 h NSS DIN EN ISO 9227

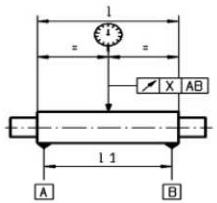
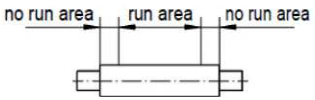
Piston rod free from cracks,
guaranteed by optical individual test or eddy current test

C (3:1)

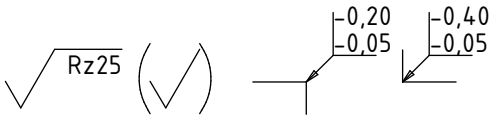


B (3:1)



Finished dimension [mm]	roughness depth after final condition
	

permissible runout			run area	no run area
X	l1	l		
0,05	50	>55	R_a = 0,06 – 0,1 µm R_z ≤ 0,90 µm	R_a ≤ 0,20 µm R_z ≤ 1,5 µm
0,10	100	>105		
0,20	150	>155		
0,30	225	>230		



Diese Zeichnung ist ausschließlich unser Eigentum.Ohne unsere Zustimmung darf sie nicht vervielfältigt,dritten Personen mitgeteilt oder anderweitig benutzt werden.	Allgemein-Toleranz ISO 2768-m	Werkstück-kanten DIN 6784	M 2:1 Art.-Nr.: Halbzg.-Nr.:
			Werkstoff: 1.0034 / E195 +C Masse: -
	Datum / Name		Kolbenstange
	Gezeichnet: 20.02.2019 jkleinn		KSB Ø14 M14x1,5x25 412mm, Ventilstößel 4
	Kontrolliert:		
	Norm:		Benennung:
	HAHN GASFEDERN		KSB_-K-00004-E1 — 1 / A3
Status / Änderungen / Datum / Name	Ersetzt durch:		Ersatz für: 440.00.015 — MOD-Nr.: KSB_-K-00004-EM