

The print-out is not subject to the modification service.

Intended for internal and supplier use

EN

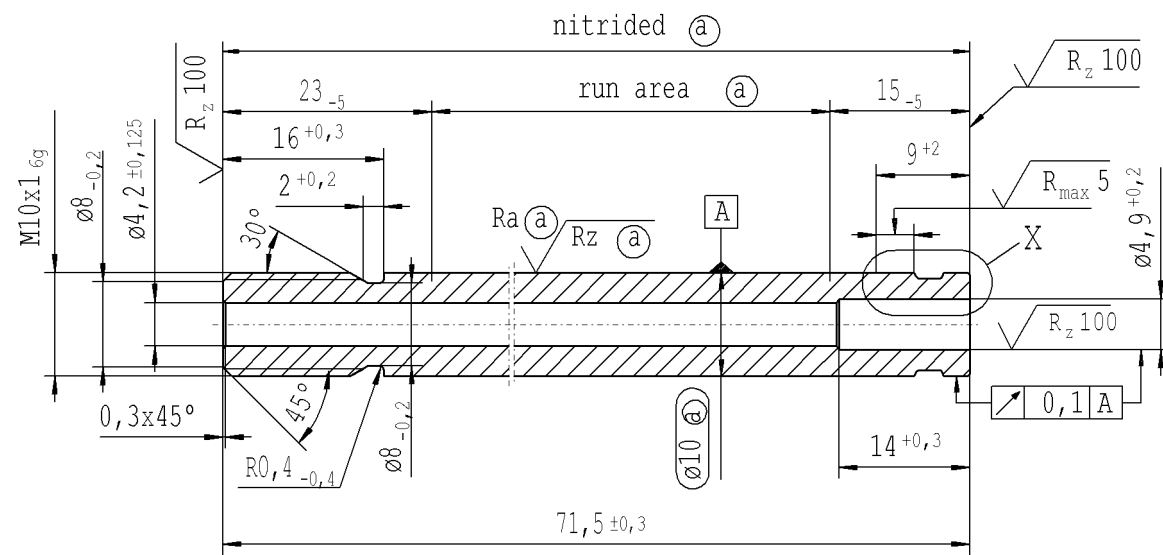
B

A

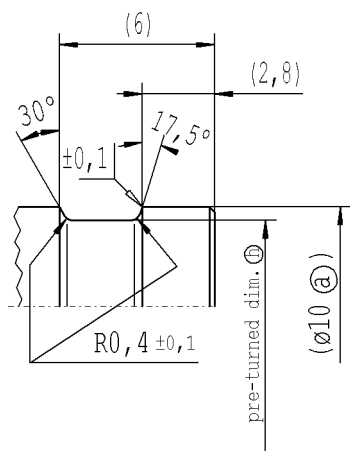
Ident. Doc.: L02

- a piston rod processing per STAB-Spec. 10028959 tab.I
- h knurl-profile manufactured with knurl roll DIN 82 - RAA 0,5

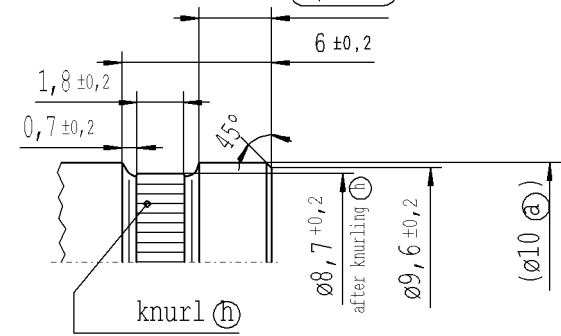
100% cleanliness of through hole



X 5:1
before knurling



X 5:1
after knurling



Control dimension!
100 % visual checking

Surface finish requirements: $\sqrt{R_z 25}$ ($\sqrt{R_z 100}$ Ra a Rz a) and $\sqrt{R_z 100}$ Ra a Rz a.

AIAG CQI-standards acc. to STAB-Spec. 10027692

Environmental protection acc. to STAB-Spec. 10005649

DE: X	EN: X	ES:	IT:	PR:	FR:	RO:
new	INITIAL RELEASE					
old	-					
Field	-					
Date/Name	09.11.2018 H3fer					
Chg. No.	672469					
Rev.	0					

RELEASE
for supplier
company Zhang Shi
Dat. 12.11.2018 Schilz A.
(date / signature)

Material: 1.1193
S45C JISG 4051
Edge tolerances acc. to DIN ISO 13715
Surface finish DIN EN ISO 1302
Replaces:
STABILUS

All dimensions are in mm
Scale: (Original DIN A3) 2:1
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Identification of important characteristics
Dimensions without tolerances DIN ISO 2768-mK
Drawn by 09.11.2018 H3fer
Checked 12.11.2018 Milles
Document No.: 10221776
Material No.: 884816