



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

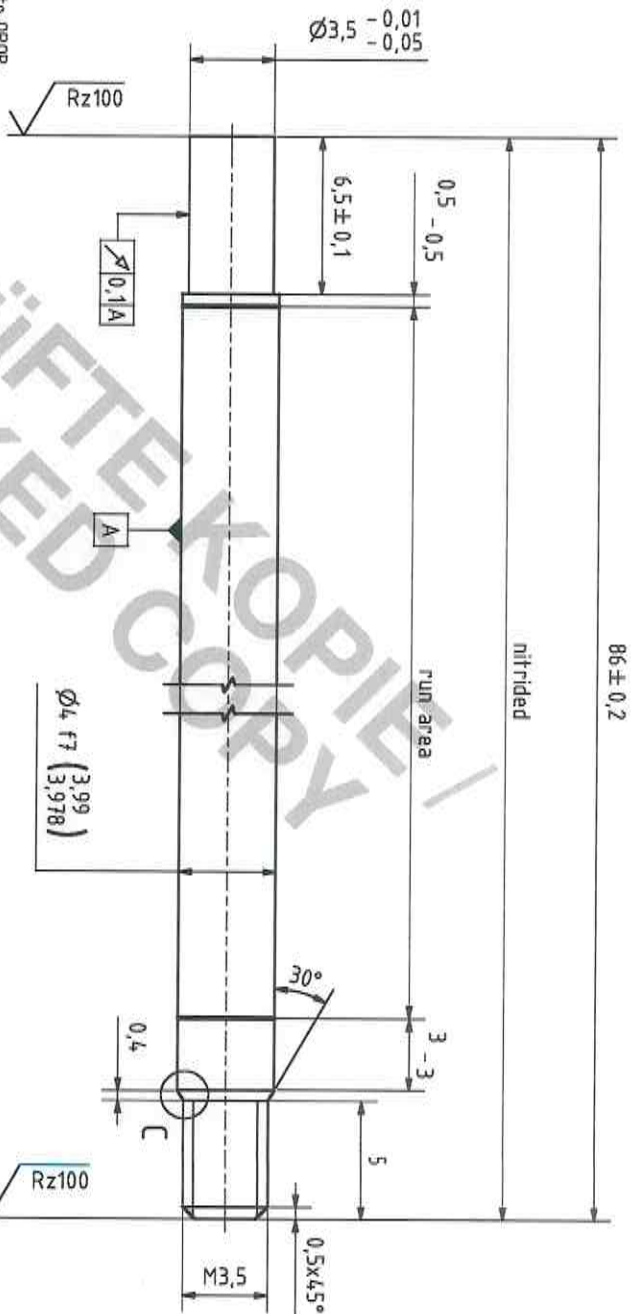
Surface treatment

Surface processing of piston rods < 800mm length according to QPQP
- process Surface hardness ≥ 430 HV 0.1 DIN EN ISO 6507-1
Corrosion resistance: 144 h NSS DIN EN ISO 9227

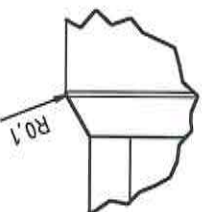
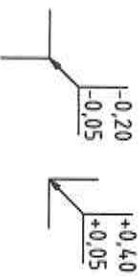
Piston rod free from cracks,

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	11	1		
0.05	50	>55	$R_a = 0.06 - 0.1 \mu\text{m}$ $R_z \leq 0.90 \mu\text{m}$ $R_a \leq 0.20 \mu\text{m}$ $R_z \leq 1.5 \mu\text{m}$	
0.10	100	>105		
0.20	150	>155		
0.30	225	>230		



C (20 : 1)


$$\sqrt{R_{225}} \left(\sqrt{\quad} \right)$$


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Material No:		478042		General- tolerances ISO 2768-m		Edge- tolerances DIN 6784		Sc.5:1 Part no: KST/05/0060/202 Rev. no: S45C	
Document No:		10270407		Drawn by: 30.11.2019 Date: 09.10.2019 Name:		Weight: 1.4305 / X8CrNiSi18-9		Material: 1.4305 / X8CrNiSi18-9	
Description: KST Ø4 M3,5x5; Nz 3,5x6,5 L=86		Drawn by: 30.11.2019 Date: 09.10.2019 Name:		Drawn by: 30.11.2019 Date: 09.10.2019 Name:		Drawn by: 30.11.2019 Date: 09.10.2019 Name:		Drawn by: 30.11.2019 Date: 09.10.2019 Name:	
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