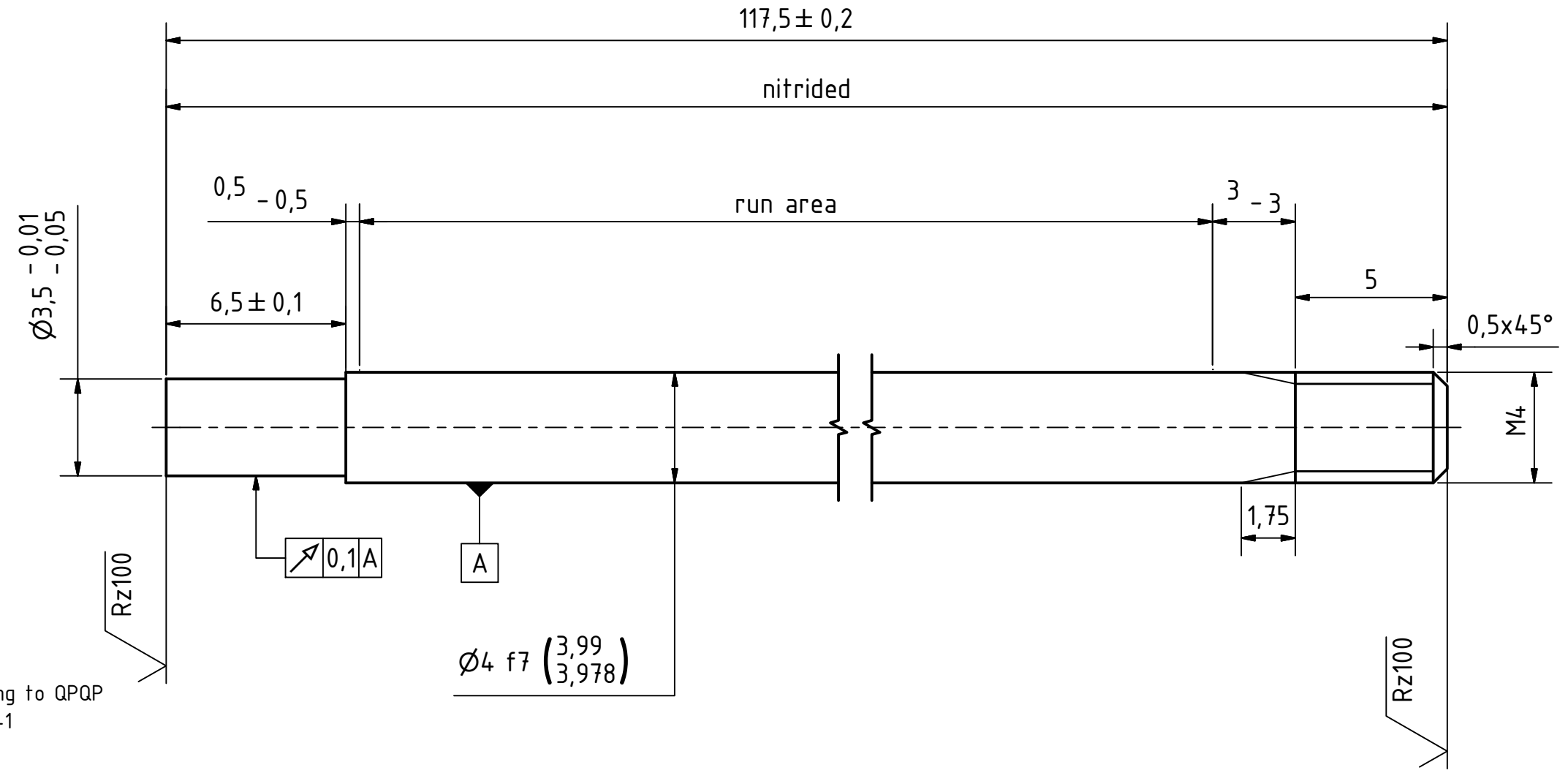


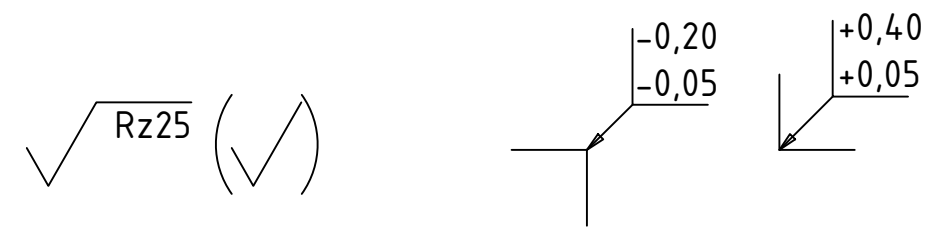
Color: brown/black
 1.) Bond zone: = 12 +10 μm
 2.) Porous zone: 2-8 μm

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 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	$R_a = 0,06 - 0,1 \mu\text{m}$ $R_z \leq 0,90 \mu\text{m}$	$R_a \leq 0,20 \mu\text{m}$ $R_z \leq 1,5 \mu\text{m}$
0,05	50	>55		
0,10	100	>105		
0,20	150	>155		
0,30	225	>230		



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				Date	Name	Material: 1.1191 / C45 E		
				Drawn by	12.02.2021	MWaldmann	Weight: -	
				Checked			KST Ø4 M4x5; Nz 3,5x6,5 L=117,5	
				Norm			Description:	
						RD-00000108-1		1
								A3
Rev.	Modification	Date	Name	Replaced by:	Replacement for:		MOD-Nr.: RD-00000108-1	