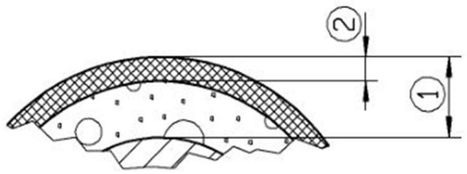
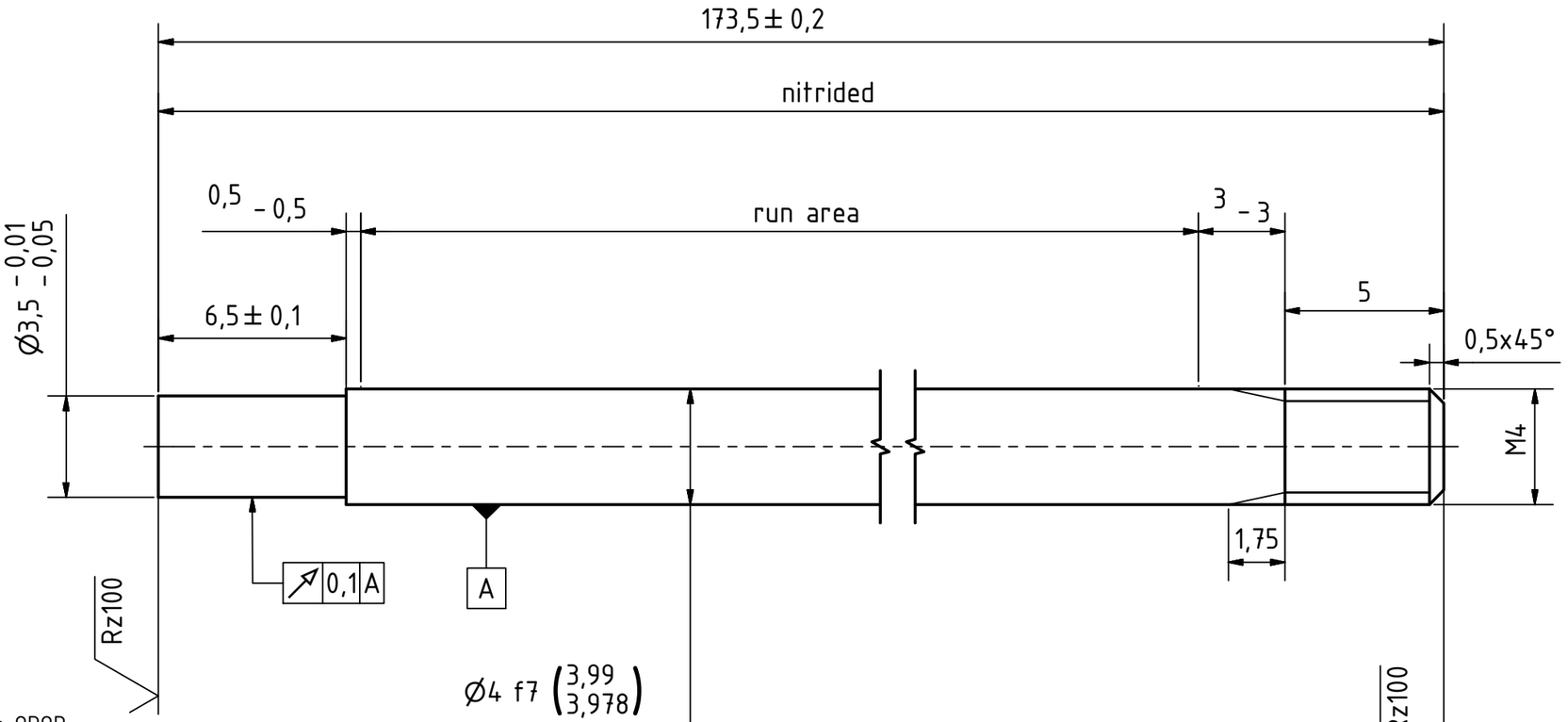
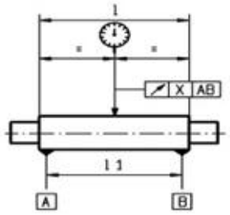


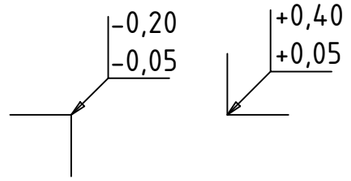
Color: brown/black
1.) Bond zone: = 12 +10 µm
2.) Porous zone: 2-8 µm



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

Finished dimension [mm]			roughness depth after final condition	
				
permissible runout			run area	no run area
X	l1	l	R_a = 0,06 – 0,1 µm R_z ≤ 0,90 µm	R_a ≤ 0,20 µm R_z ≤ 1,5 µm
0,05	50	>55		
0,10	100	>105		
0,20	150	>155		
0,30	225	>230		



We reserse all rights to this document, to any patents or patent registrations related hereto, any to the duplication, retransmission by third parties and misc. use. Any use of this document is not permitted without the written consent of HAHN-Gasfedern.

	General-tolerance ISO 2768-m	Edge-tolerances DIN 6784

	Date	Name
Drawn by	12.02.2021	MWaldmann
Checked		
Norm		

Rev.	Modification	Date	Name

Replaced by:

Sc.5:1 | Art.-Nr.: | Wrought mat.: S45C

Material: 1.1191 / C45 E
Weight: -

KST Ø4 M4x5; Nz 3,5x6,5 L=173,5

Description:

RD-00000109-1 | 1 | A3

Replacement for: | MOD-Nr.: RD-00000109-1