

Color: brown/black

1.) Bond zone: $\approx 12 +10 \mu\text{m}$

2.) Porous zone: $2-8 \mu\text{m}$

Surface treatment

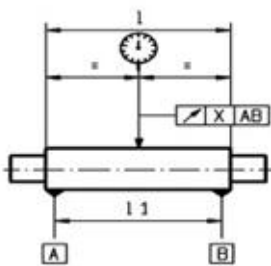
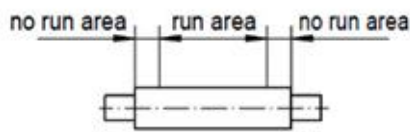
Surface processing of piston rods $< 800\text{mm}$ length according to QPQP

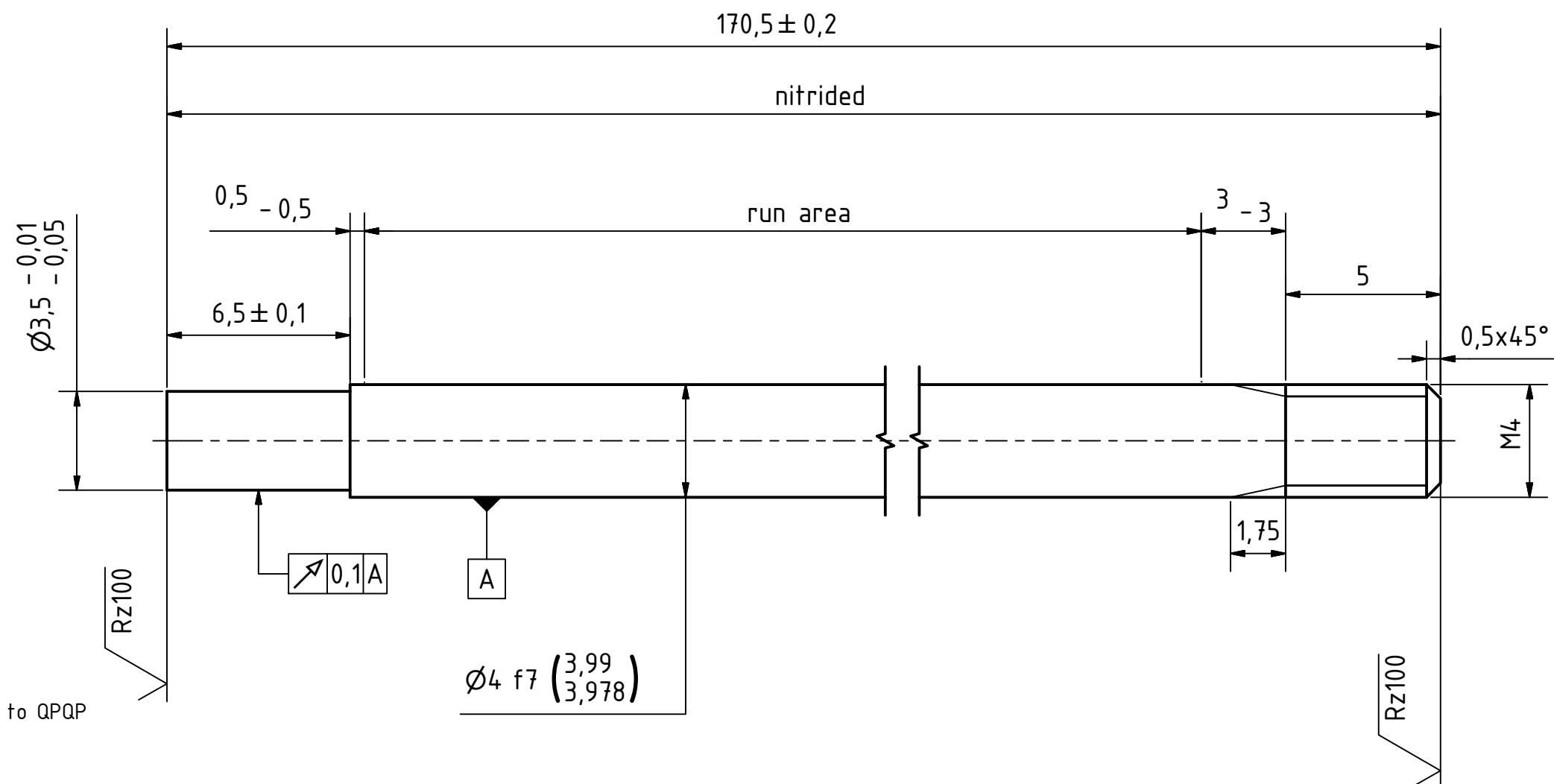
- process Surface hardness $\geq 430 \text{ HV } 0,1 \text{ DIN EN ISO 6507-1}$

Corrosion resistance: $144 \text{ h NSS DIN EN ISO 9227}$

Piston rod free from cracks,

guaranteed by optical individual test or eddy current test

Finished dimension [mm]	roughness depth after final condition	
		
permissible runout		
X	l1	l
0,05	50	>55
0,10	100	>105
0,20	150	>155
0,30	225	>230
$R_a = 0,06 - 0,1 \mu\text{m}$ $R_z \leq 0,90 \mu\text{m}$		$R_a \leq 0,20 \mu\text{m}$ $R_z \leq 1,5 \mu\text{m}$



$\sqrt{Rz25}$ (✓)

$-0,20$
 $-0,05$
 $+0,40$
 $+0,05$

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				Date	Name	Material: 1.1191 / C45 E		
				Drawn by	MWaldmann	Weight: -		
				Checked		KST Ø4 M4x5; Nz 3,5x6,5 L=170,5		
				Norm		Description:		
				HAHN GASFEDERN		RD-00000112-1		1
				Replaced by:		Replacement for:		A3
Rev.	Modification	Date	Name	Replaced by:		MOD-Nr.: RD-00000112-1		