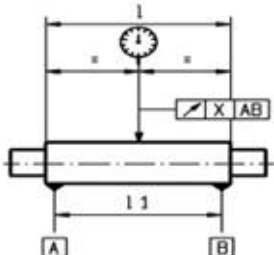
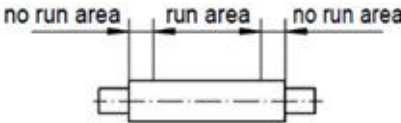
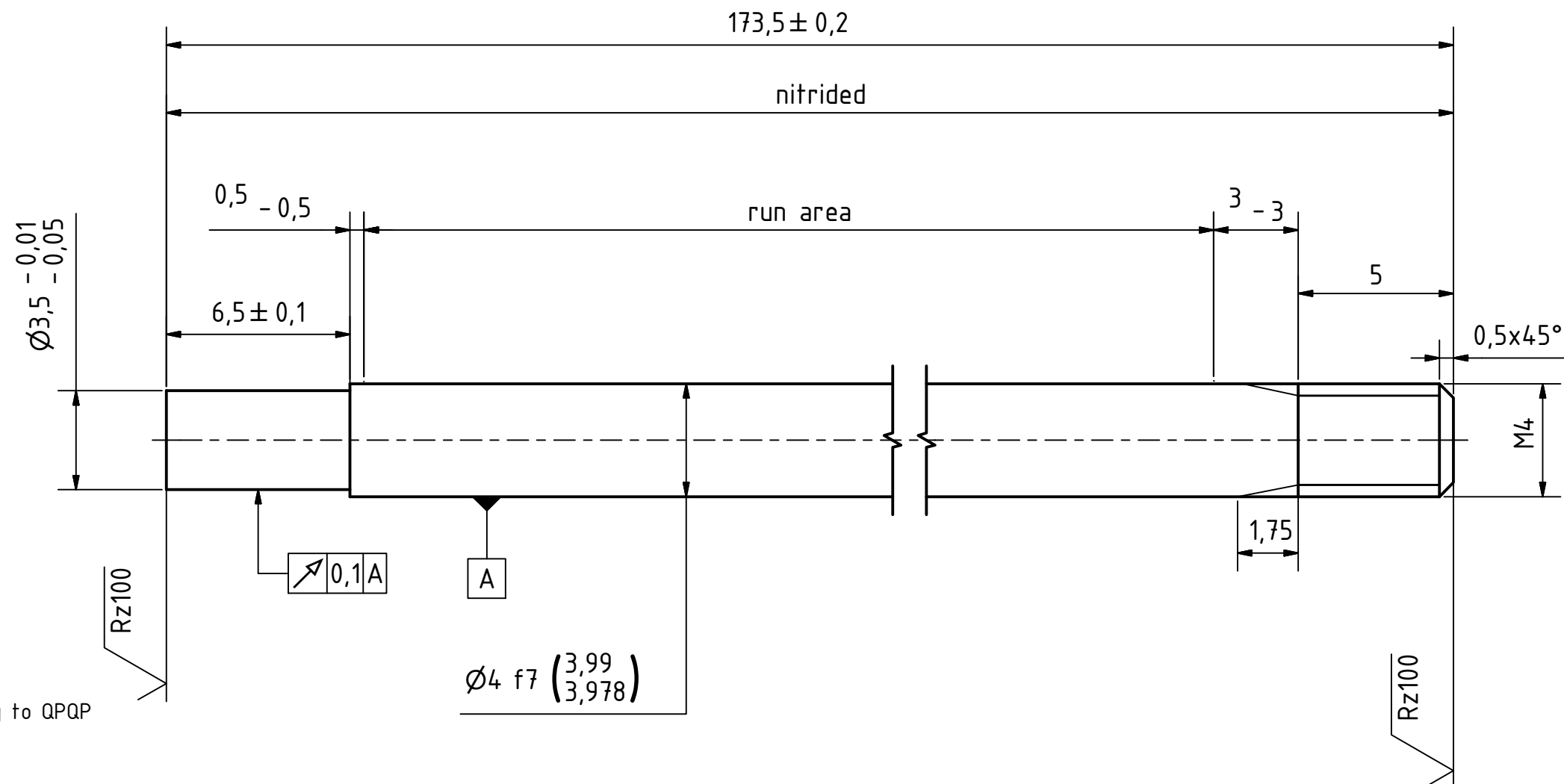


Surface treatment
Surface processing of piston rods < 800mm length according to QPQP
- process Surface hardness ≥ 430 HV 0,1 DIN EN ISO 6507-1
Corrosion resistance: 144 h NSS DIN EN ISO 9227

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															
<table><tr><td>X</td><td>l1</td><td>l</td></tr><tr><td>0,05</td><td>50</td><td>>55</td></tr><tr><td>0,10</td><td>100</td><td>>105</td></tr><tr><td>0,20</td><td>150</td><td>>155</td></tr><tr><td>0,30</td><td>225</td><td>>230</td></tr></table>	X	l1	l	0,05	50	>55	0,10	100	>105	0,20	150	>155	0,30	225	>230	$R_a = 0,06 - 0,1 \mu m$ $R_z \leq 0,90 \mu m$	$R_a \leq 0,20 \mu m$ $R_z \leq 1,5 \mu m$
X	l1	l															
0,05	50	>55															
0,10	100	>105															
0,20	150	>155															
0,30	225	>230															



$\sqrt{\text{Rz25}} \left(\sqrt{} \right)$

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								Material: 1.1191 / C45 E						Weight:	
					Date	Name		KST Ø4 M4x5; Nz 3,5x6,5							
				Drawn by	28.05.2021	UGneiting									
				Checked	01.04.2021										
				Norm											
				 HAHN GASFEDERN A STABILUS COMPANY				Description:							
								RD-00000589-6						1	
														A3	
Rev.	Modification	Date	Name	Replaced by:				Replacement for:				MOD-Nr.: RD-00000589-1			