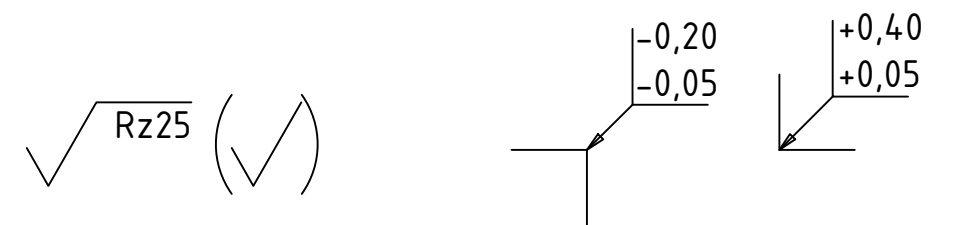
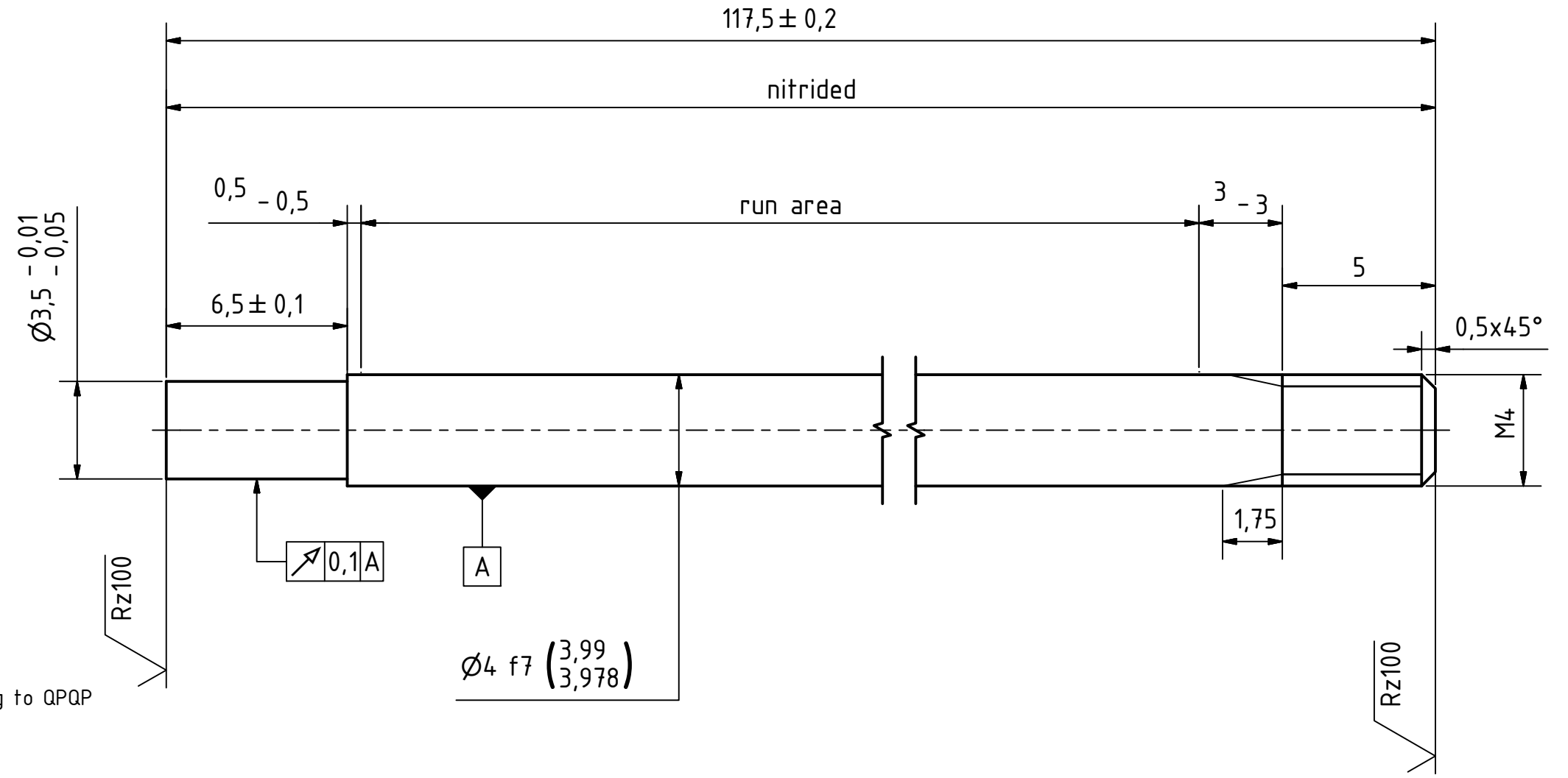


Color: brown/black
 1.) Bond zone: = 12 +10 μm
 2.) Porous zone: 2-8 μm

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 | |
|-------------------------|-----|------|---|---|
| | | | no run area | |
| | | | run area | |
| 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 | | |



| | | | | | | | | |
|--|--------------|------|------|------------------------------|--------------------------|--------------------------|------------------------|--------------------|
| We reserve 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 | Sc. 5:1 | Art.-Nr.: | Wrought mat.: S45C |
| | | | | Date | Name | Material: 1.1191 / C45 E | | |
| | | | | Drawn by | UGneiting | Weight: | | |
| | | | | Checked | 01.04.2021 | KST Ø4 M4x5; Nz 3,5x6,5 | | |
| | | | | Norm | | Description: | | |
| | | | | | | RD-00000589-4 | | 1 |
| | | | | | | Replacement for: | | A3 |
| Rev. | Modification | Date | Name | Replaced by: | Replacement for: | | MOD-Nr.: RD-00000589-1 | |