

Color: brown/black

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

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

Surface treatment

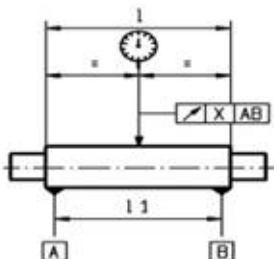
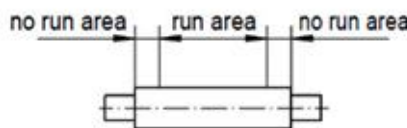
Surface processing of piston rods < 800mm length according to QPQP

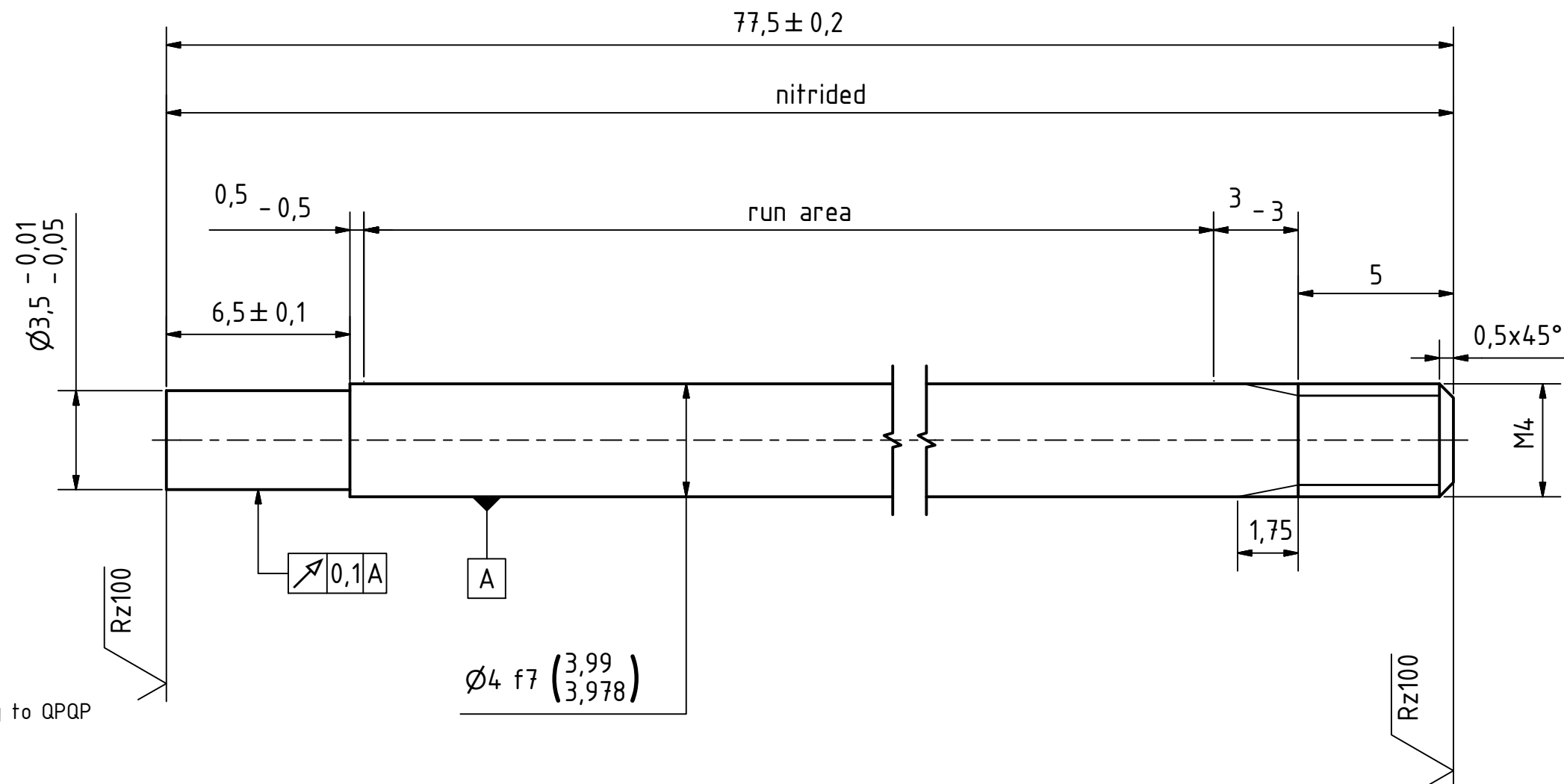
- process Surface hardness $\geq 430 \text{ HV } 0,1 \text{ DIN EN ISO 6507-1}$

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		



$\sqrt{Rz25}$ (✓)

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

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				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-00000589-5		1
				Replaced by:		Replacement for:		A3
Rev.	Modification	Date	Name	Replaced by:		MOD-Nr.: RD-00000589-1		