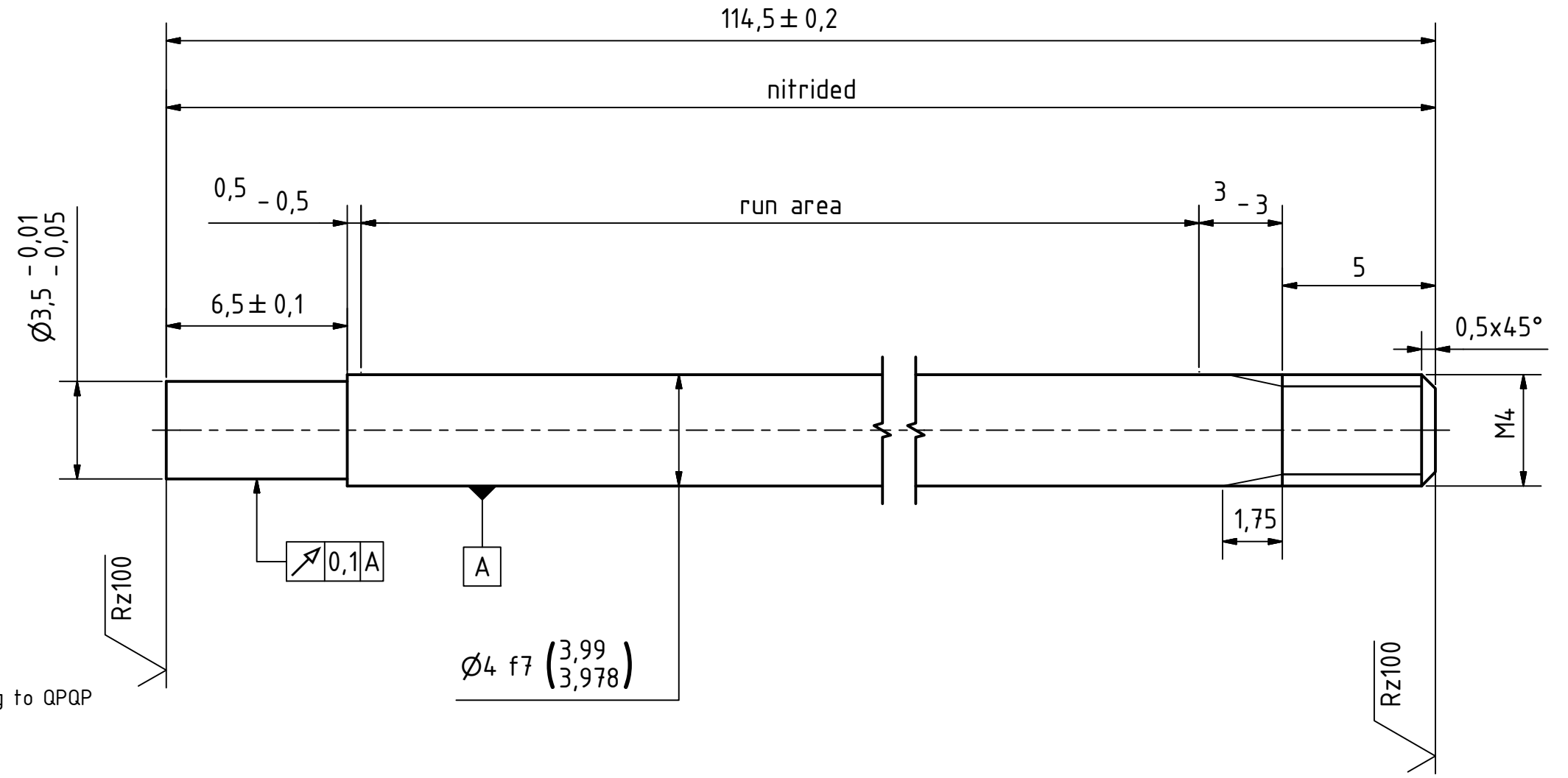


Color: brown/black  
 1.) Bond zone: = 12 +10 µm  
 2.) Porous zone: 2-8 µm

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