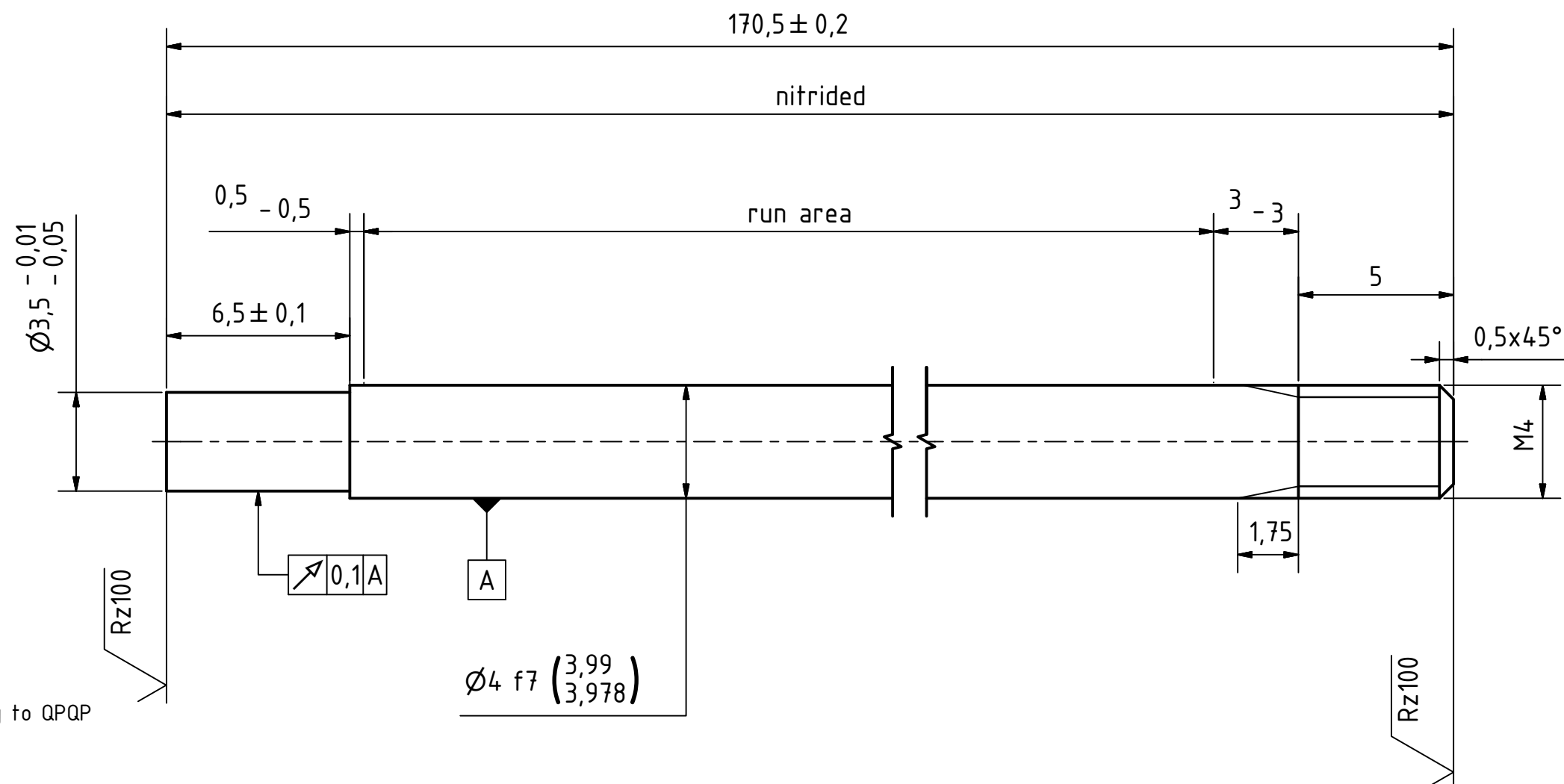


Color: brown/black
 1.) Bond zone: $\approx 12 +10 \mu\text{m}$
 2.) Porous zone: $2-8 \mu\text{m}$

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			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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								Material: 1.1191 / C45 E						
								Weight:						
					Date	Name								
				Drawn by	28.05.2021	UGneiting								
				Checked	05.08.2021	CAupperle								
				Norm										
						Scale 1:1								
B	Artikelnummer KST/04/0170/001 hinzu		05.08.2021	UGneiting		 HAHN GASFEDERN A STABILUS COMPANY		Description:				1		
RD-00000589-2								A3						
Rev.	Modification		Date	Name	Replaced by:		Replacement for:				MOD-Nr.: RD-00000589-1			