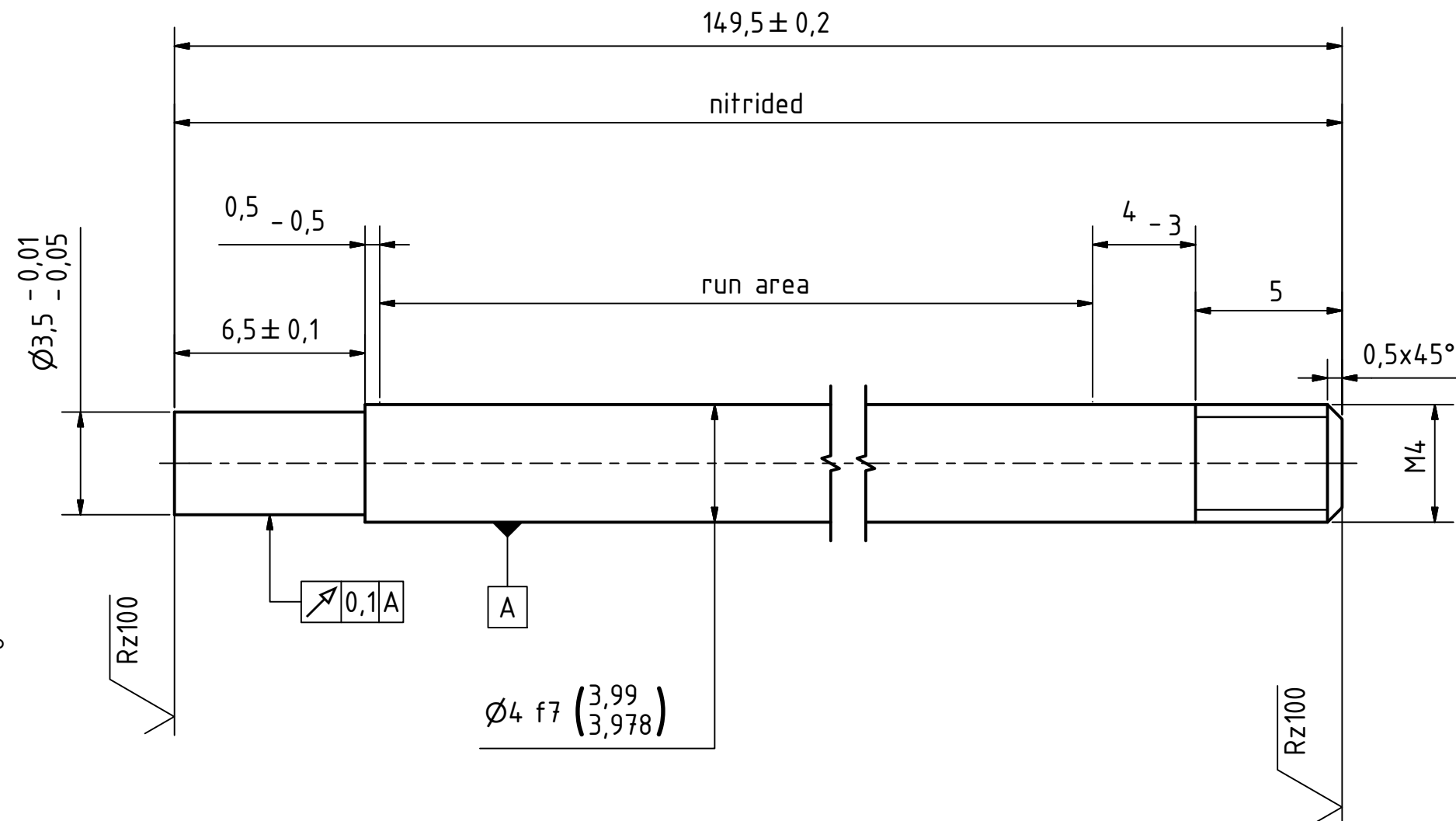


Color: brown/black
 1.) Bond zone: = 12 +10 µm
 2.) Porous zone: 2-8 µm

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



Fertigmaß [mm] Finished dimension [mm]			Rauheit nach dem letzten Arbeitsschritt roughness depth after final condition	
zulässige Unrundheit permissible runout			Laufbereich run area	kein Laufbereich no run area
X	l1	l	Ra = 0,06-0,1 µm Rz = ≤ 0,90 µm Rmr (TP) 50-70 % C = 25µm, 5%	Ra ≤ 0,20 µm Rz ≤ 1,5 µm Rmr (TP) 50-70% C = 25µm, 5%
0,05	50	>55		
0,10	100	>105		
0,20	150	>155		
0,30	225	>230		



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				Date	Name	Material: 1.1191 / C45 E		
				Drawn by	UGneiting	Weight:		
				Checked	AKompos	KST Ø4 M4x5; Nz 3,5x6,5 Hub=125		
				Norm		L=149,5		
						Description:		
						RD-00001410-1		1
						Replacement for:		A3
Rev.	Modification	Date	Name	Replaced by:		MOD-Nr.: RD-00001410-1		