

Color: dark grey/anthracite

Bond zone : $\geq 12 \mu\text{m}$ (1)

Oxide zone: $\geq 1 \mu\text{m}$ (2) in the polished condition!

Table X Nislide "G"

Nislide "G" processing of piston rods < 800 mm long acc. to

STAB-Spec.10006599

Surface hardness: $\geq 430 \text{ HV } 0,5$ DIN EN ISO 6507-1

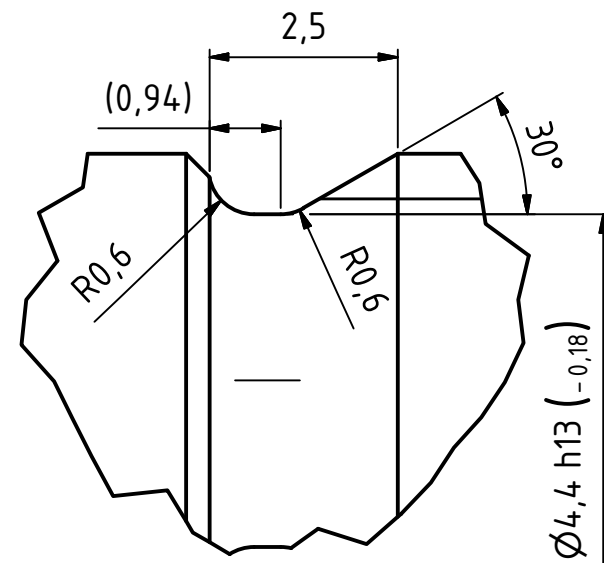
(plasmanitriding)

Corrosion resistance: $\geq 144 \text{ h NSS}$ DIN EN ISO 9227

(= ASTM B 117 für STUS)

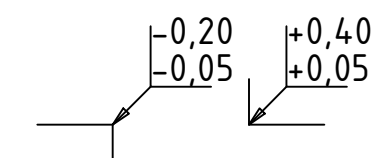
Piston rod free from cracks guaranteed by optical individual test or eddy current test

Nominal Ø [mm]	Runout before grinding [mm]	grinding dimension before surface treatment [mm]	roughness depth after grinding	Finished size [mm]	Finished condition [mm]
4	<p>permissible runout</p>	-0,042 -0,051	$R_{\text{max}} \leq 1,5 \mu\text{m}$	-0,002 -0,049	<p>permissible runout</p>
6		-0,040 -0,051		-0,008 -0,055	
8		-0,046 -0,057		-0,014 -0,062	
10		-0,054 -0,066		-0,046 -0,062	
11		-0,054 -0,066		-0,046 -0,062	
12		-0,054 -0,066		-0,046 -0,062	
14		-0,054 -0,066		-0,046 -0,062	
16	0,15 (0,08)*	150 >155 225 >230	0,80	150 >155 225 >230	
20				-0,020 -0,070	



A (10 : 1)

$\sqrt{Rz25}$ (✓)



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Date		Name	Material:			
Drawn by 25.04.2022		UGneiting	Weight:			
Checked 31.03.2014			Kolbenstange			
Norm			KST Ø6 M6x7; NZ 5x9 L=99			
			Description:			
			RD-00001966-1		1	
					A3	
Rev.	Modification	Date	Name	Replaced by:	Replacement for:	MOD-Nr.: RD-00001966-1

