

The print-out is not subject to the modification service.

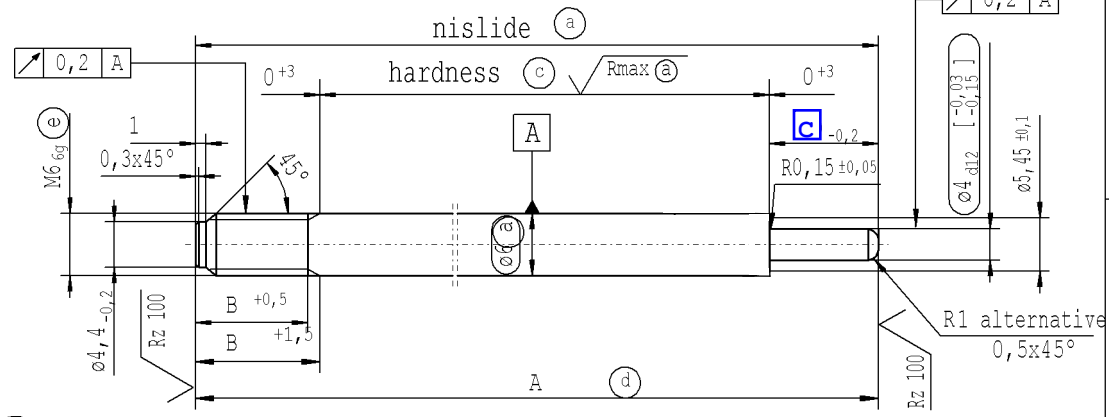
Intended for internal and supplier use

EN

Ident. Doc.:

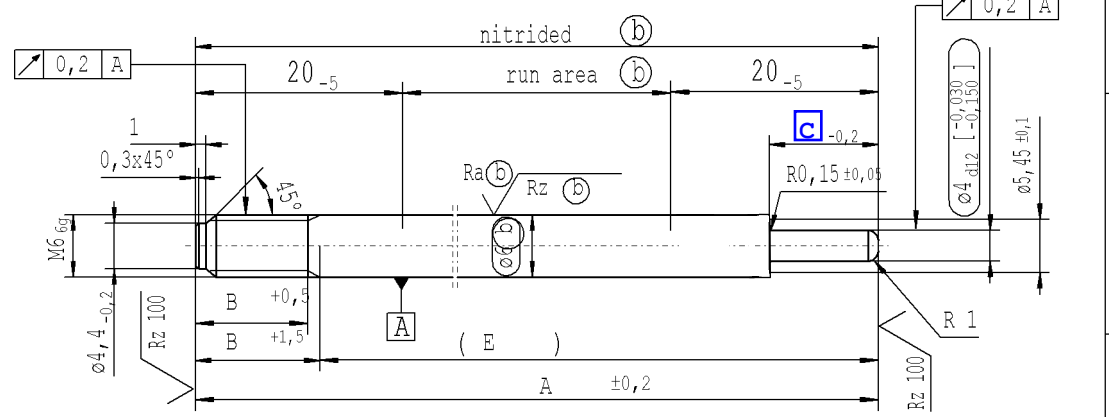
supp No.	material no.	A	B	C
	processing and surface treatment acc. to STAB-Spec. 10006248 Tab. IV 10006248 Tab. VIII 10028959 Tab. I	overall length	thread length	stud length piston side
	(a) version 1    (a) version 1    (b) version 2			
<b>x</b>	<b>xxxxxxx</b>		<b>198</b>	<b>6</b>
24	535890		93	8.5
25	536846		120	8.5
26	537802		111	8.5
27	541148		132	8.5

version 1 (only self-manufacturing) \* material: 010707



- (c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370
- (d) tolerances: +0,2 after turning; +0,2 after straightening; +0,2 after nisliding
- (e) threaded stud rough-turned dim.  $\phi 5,29_{-0,06}$  thread roll tolerance 6e thread tolerances acc. to DIN ISO 965-3

version 2 (only external production) \* material: 1.1193 S45C JISG 4051



thread tolerances acc. to DIN ISO 965-3 approved lengths: 50-600 mm

$\sqrt{Rz\ 25}$  ( $\sqrt{Rz\ 100}$   $\sqrt{Rmax\ (a)}$   $\sqrt{Ra\ (b)}$   $\sqrt{Rz\ (b)}$ )  $\downarrow +0,2$   $\downarrow -0,2$

sheet 2  
of 2

AIAG CQI-standards acc. to STAB-Spec. 10027692

Environmental protection acc. to STAB-Spec. 10005649

DE: X	EN: X	ES:	IT:	PR:	FR:	RO: X	CRD created document; handwritten changes not permitted		Material: *	All dimensions are in mm	Marking of special characteristics according to STAB-Spec. 10270932	Date: 06.06.2012	Name: Donat
new	new format Internal/Supplier		DE: Vordrehmaß ... $\phi 5,29$		Tab 3 deleted, no technical change, no new first sample required					Scale: (Original DIN A3) 2:1	Dimensions without tolerances DIN ISO 2768-mK	Checked: 02.06.2021	Milles
old	Supplier drawing separately		DE: Vordrehmaß ... $\phi 5,19$						Edge tolerances acc. to DIN ISO 13715				
Field			D4						Surface finish DIN EN ISO 1302	We reserve all rights to this document, to any patents or patent registrations related hereto, and to the duplication, retransmission by third parties and misc. use. Any use of this document is not permitted without the written consent of STABILUS.			
Date/Name	17.09.2020 Donat		10.05.2021 Jablonski		02.06.2021 Jablonski				Replaces:	Document No.: 10190070			
Chg. No.	691248		698020		697821					Material No.: <span style="border: 1px solid blue; padding: 2px;">NEW</span>			
Rev.	9		10		10				<b>STABILUS</b>	<b>PISTON ROD</b>			

