

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

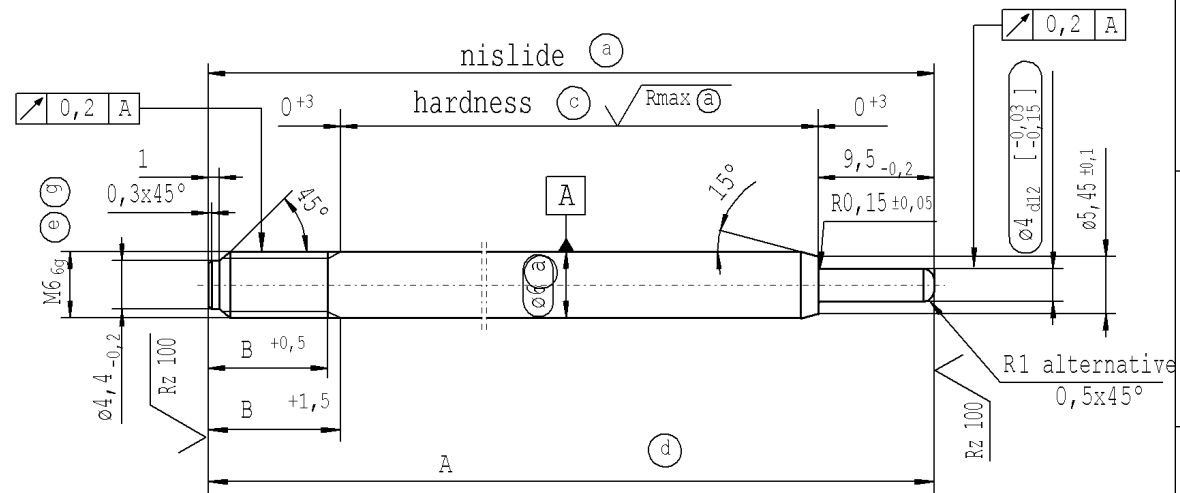
Intended for internal and supplier use

EN

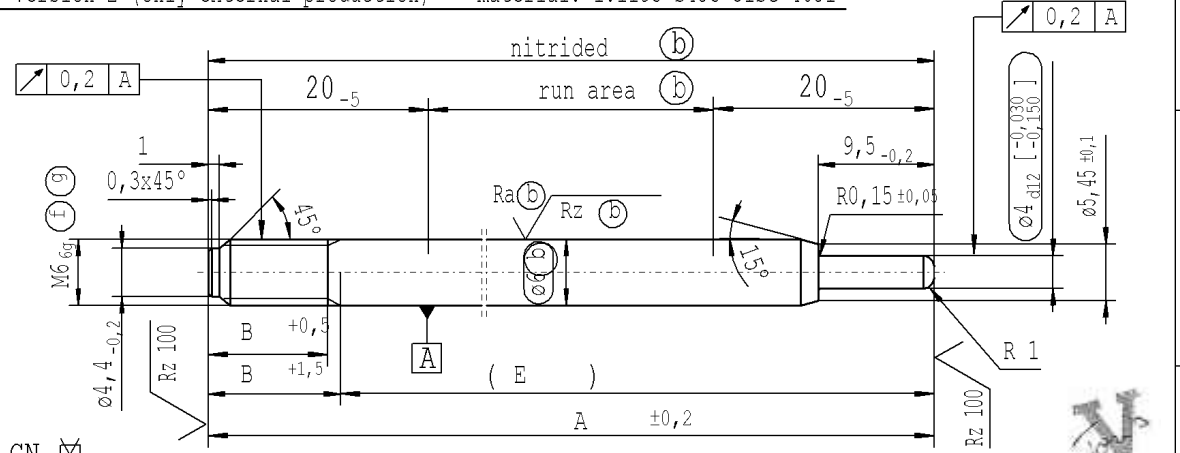
Ident. Doc. :  
revs11.datum: 21/11/2022 - 6:46

supp No.	material no.			A	B
	processing and surface treatment acc. to STAB-Spec. 10006248 Tab. XVI optimized 10006248 Tab. X 10028959 Tab. I			overall length	thread length
	(a) version 1	(a) version 1	(b) version 2		
1	505017	505017	505017	96	6
3	884085	884085	884085	189	6
5	889107	889107	889107	189	8.5
6	890302	890302	890302	99	8.5
7	891019	891019	891019	117	8.5
8	891736	891736	891736	138	8.5
9	892453	892453	892453	126	8.5
10	893170	893170	893170	78	8.5
11	339886	339886	339886	159	8.5
13	811197	811197	811197	126	6
14	264367	264367	264367	138	6
15	277751	277751	277751	117	6
16	883138	883138	883138	123	8.5
17	606859	606859	606859	159	6
18	071261	071261	071261	108	6
19	338226	338226	338226	90	6
20	532301	532301	532301	153	8.5
21	208697	208697	208697	120	6
22	412088	412088	412088	114	6
23	529198	529198	529198	183	8.5

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



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



- (c) before grinding:  
Hardness depth and hardness test acc. to STAB-Spec. 10258370
- (d) tolerances:  $\begin{matrix} +0,2 \\ -0,1 \end{matrix}$  after turning;  
 $\pm 0,2$  after straightening;  
 $\pm 0,2$  after nisliding
- (e) threaded stud rough-turned dim.  $\phi 5,29_{-0,06}$   
thread roll tolerance 6e  
acc. to DIN ISO 965-3
- (f) rough-turned dim. thread roll tolerance 6e
- (g) In the final condition, the actual profile of the thread must not exceed the maximum material limit for the tolerance zone position h at any point

ZS CN   
ZS RO

thread tolerances acc. to DIN ISO 965-3

approved lengths: 50-600 mm

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

sheet 1  
of 4

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	CAD created document; handwritten changes not permitted	Material: *	All dimensions are in mm	Marking of special characteristics according to STAB-Spec. 10270932	Date	Name	
new	DE: Vordrehmaß ... $\phi 5,29$			Tab X deleted, no technical change, no new first sample required	ZS CN / ZS RO; M6 6g (f) (g)	Tab. XVI; Tab. X			Scale: (Original DIN A3) 2:1	Dimensions without tolerances DIN ISO 2768-mK	Drawn by	06.06.2012	Donat
old	DE: Vordrehmaß ... $\phi 5,19$					Tab. IV; Tab. VIII		Edge tolerances acc. to DIN ISO 13715			Checked	11.10.2022	Klinkner
Field	D4					B-C/5; E-F/5, -		Surface finish DIN EN ISO 1302			Document No.:	10190070	
Date/Name	10.05.2021 Jablonski			02.06.2021 Jablonski		11.10.2022 Hein		Replaces:			Material No.:		
Chg. No.	698020			697821		712940							
Rev.	10			10		11							
<b>STABILUS</b>								<b>PISTON ROD</b>					