

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

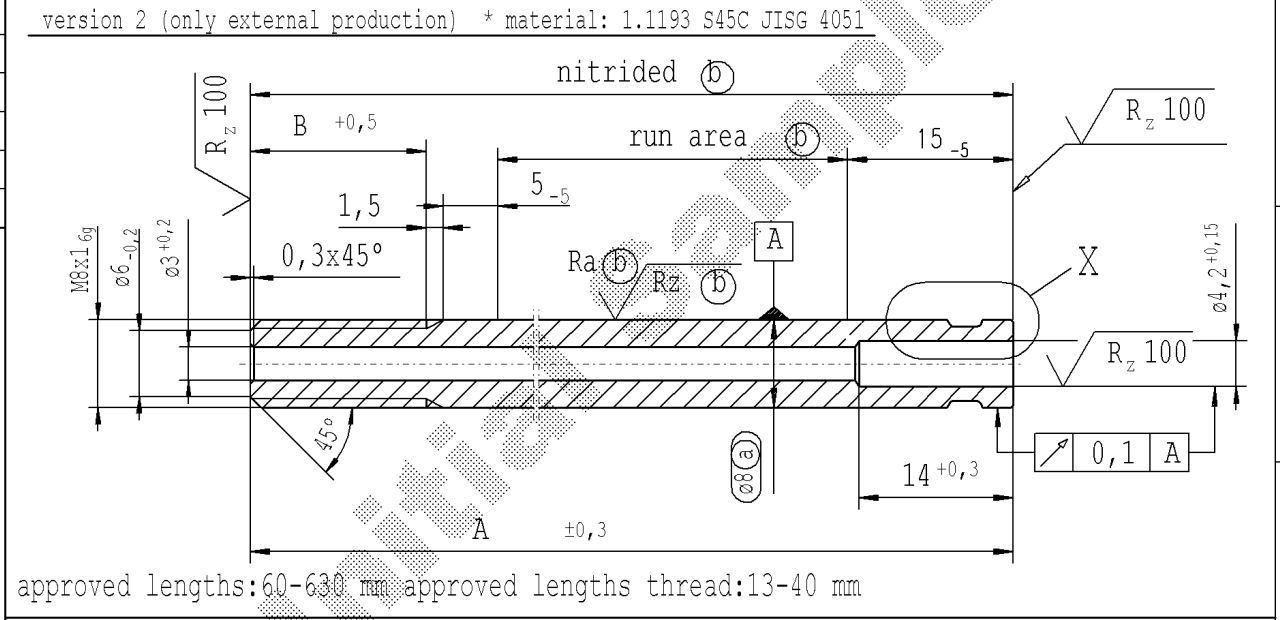
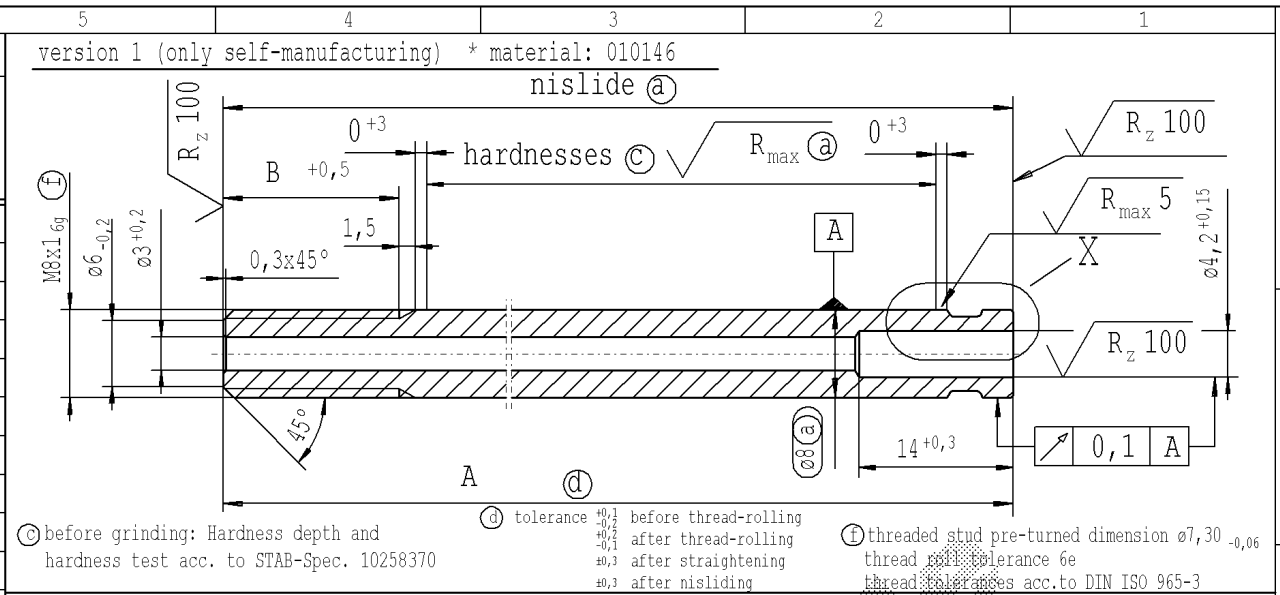
Intended for internal and supplier use

EN

Brevet.datum: 2/6/2002 - 9:46

Ident. Doc.:

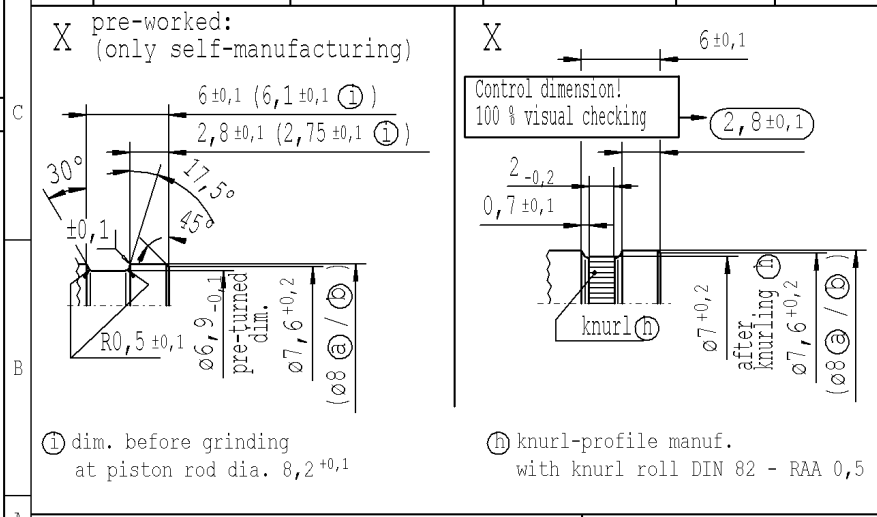
supp No.	material no.			A	B
	processing and surface treatment acc. to STAB-Spec.: 10006248 Tab. IV (a) version 1	10006248 Tab. X (a) version 1	10028959 Tab. I (b) version 2	overall length	stud length end-fitting side
1	008780	008780		83.5	16
2	948878	948878		350.5	16
3	949834	949834		410.5	16
4	008845	008845		71.5	16
5	008846	008846		77.5	16
6	008847	008847		62.5	16
7	008849	008849		182.5	16
8	008851	008851		85.0	22
9	962501	962501		398.5	16
10	963218	963218		374.5	16
11	652965	652965		74.5	16
12	508855	508855		119.5	16
13	368326	368326		92.5	16
14	963696	963696		344.5	16
15	965369	965369		326.5	16
16	966086	966086		319.5	16



100% cleanliness of through hole

$\sqrt{Rz 25}$ ($\sqrt{Rz 100}$ $\sqrt{Rmax 5}$ $\sqrt{Rmax (a)}$ $Ra (b)$ $Rz (b)$) $\begin{matrix} +0,2 \\ -0,2 \\ \pm 0,1 \end{matrix}$

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		
new	marking groove removed	© = acc. STAB-Spec. 10258370		100% cleanliness of through hole		new format Internal/Supplier	*			Marking of special characteristics according to STAB-Spec. 10270932			
old	-	© = RHT 0,4 ... 0,7 mm		Permanent additional inspection 014/01		Supplier drawing separately	Edge tolerances acc. to DIN ISO 13715			Scale: (Original DIN A3) 2:1			
Field	-	C 7-8		B/5-6		-	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	12.06.2014 Hein	15.05.2019 Donat		08.06.2021 Hein		25.06.2021 Jablonski	Replaces:			Document No.: 10152217			
Chg. No.	614235	678703		677895		698589	STABILUS			Material No.:			
Rev.	5	6		7		8	PISTON ROD						

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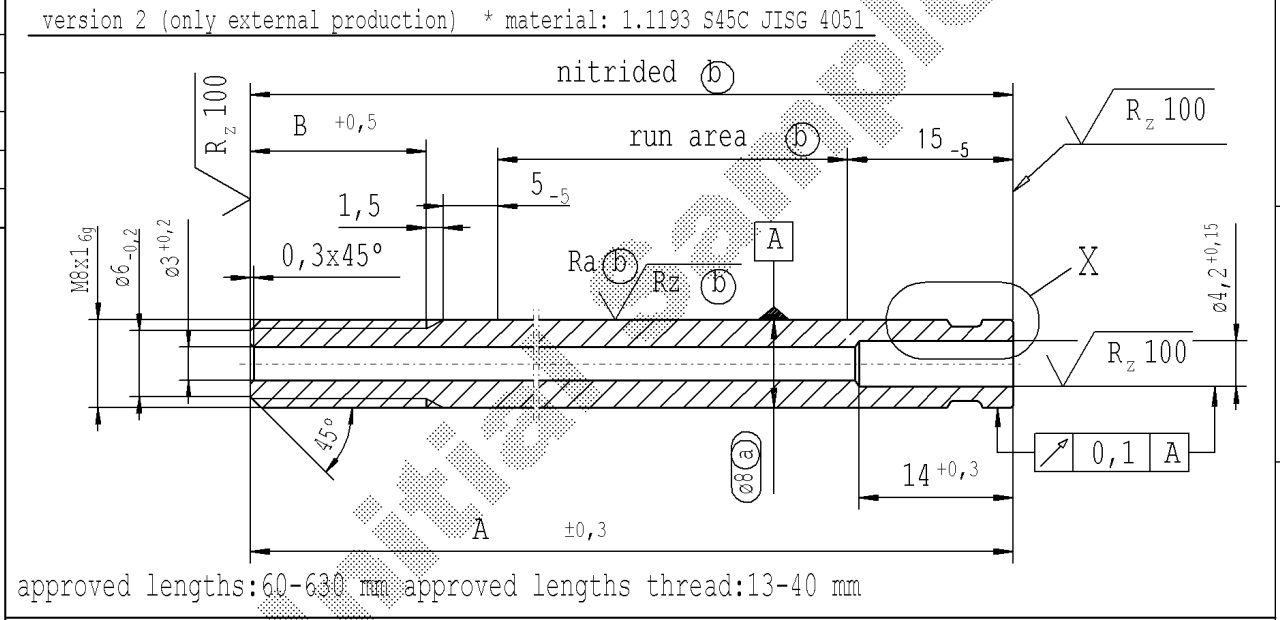
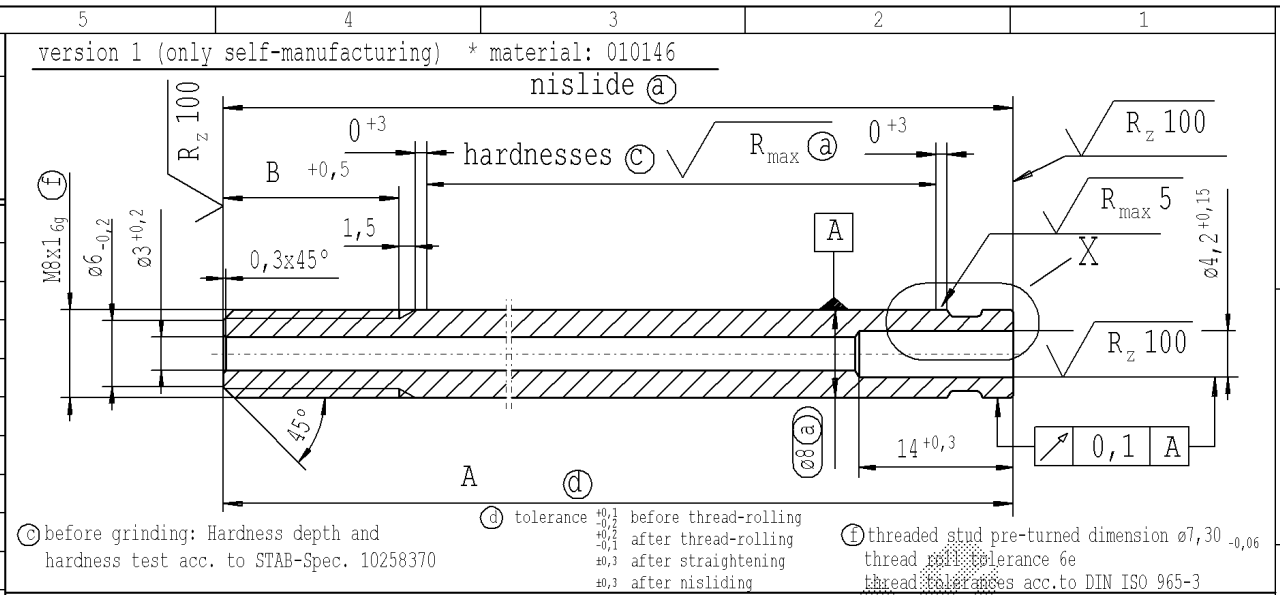
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Date/Name

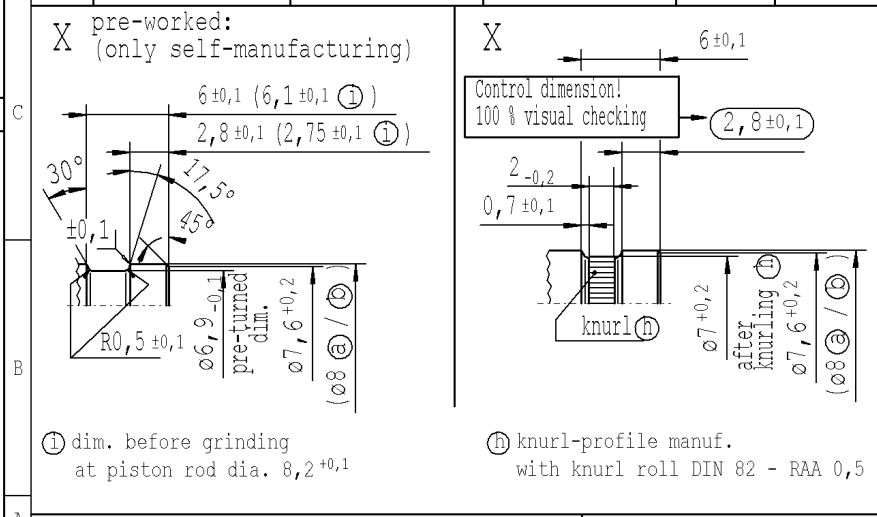
supp No.	material no.			A	B
	processing and surface treatment acc. to STAB-Spec.: 10006248 Tab. IV (a) version 1	10006248 Tab. X (a) version 1	10028959 Tab. I (b) version 2	overall length	stud length end-fitting side
17	093020	093020		355.5	20
18	094454	094454		352.5	16
19	113335	113335		323.5	16
20	114052	114052		317.5	16
21	114530	114530		395.5	16
22	115008	115008		347.5	16
23	118354	118354		341.5	16
24	118832	118832		362.5	20
25	119788	119788		392.5	16
26	120266	120266		320.5	18
27	123373	123373		440.5	16
28	123851	123851		419.5	16
29	124329	124329		401.5	16
30	125763	125763		341.5	18
31	126480	126480		365.5	16
32	297843	297843		598.5	16



100% cleanliness of through hole

$\sqrt{Rz 25}$ ($\sqrt{Rz 100}$ $\sqrt{Rmax 5}$ \sqrt{Rmax} (a) Ra (b) Rz (b))
 $\sqrt{0,2}$ $\sqrt{-0,2}$ $\sqrt{\pm 0,1}$

sheet 2 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	
new	marking groove removed	Ⓒ = acc. STAB-Spec. 10258370		100% cleanliness of through hole		new format Internal/Supplier	
old	-	Ⓒ = RHT 0,4 ... 0,7 mm		Permanent additional inspection 014/01		Supplier drawing separately	
Field	-	C 7-8		B/5-6		-	
Date/Name	12.06.2014 Hein	15.05.2019 Donat		08.06.2021 Hein		25.06.2021 Jablonski	
Chg. No.	614235	678703		677895		698589	
Rev.	5	6		7		8	

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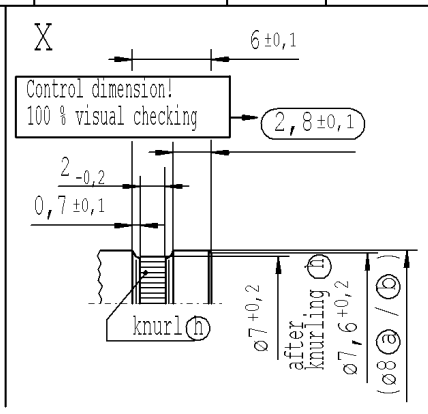
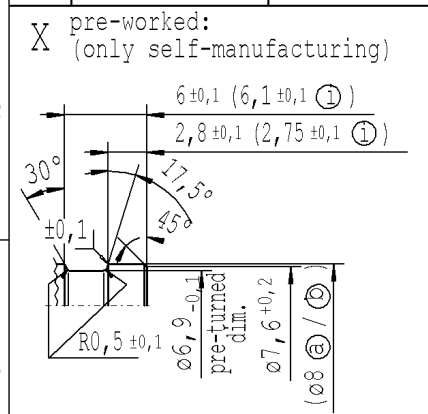
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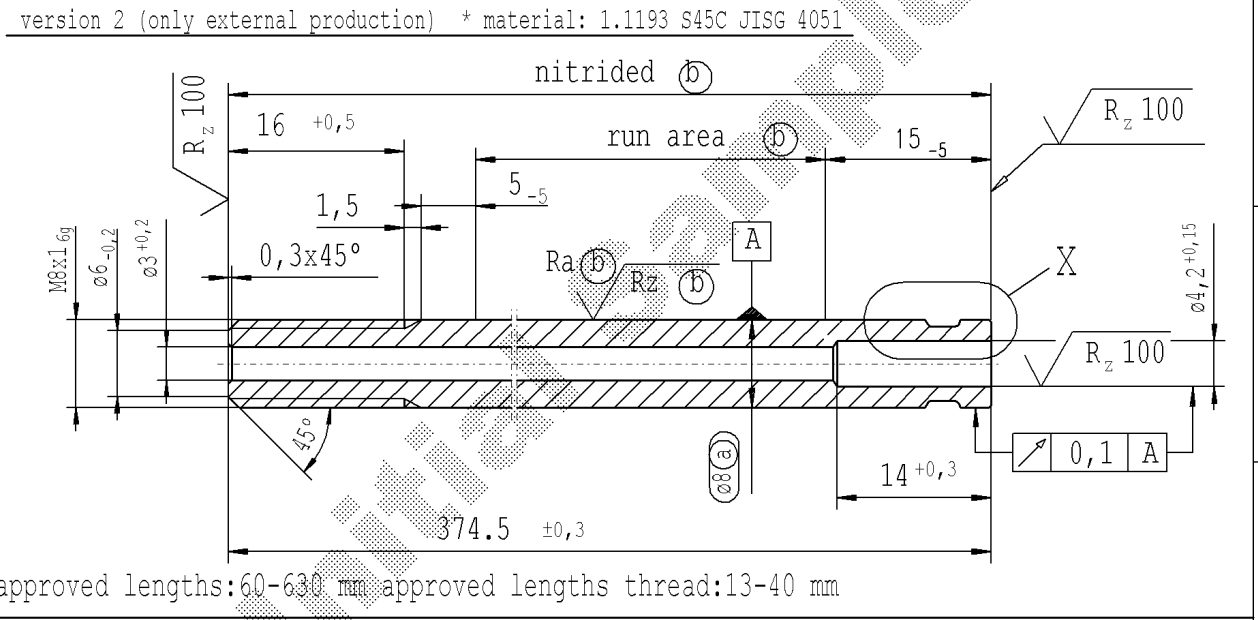
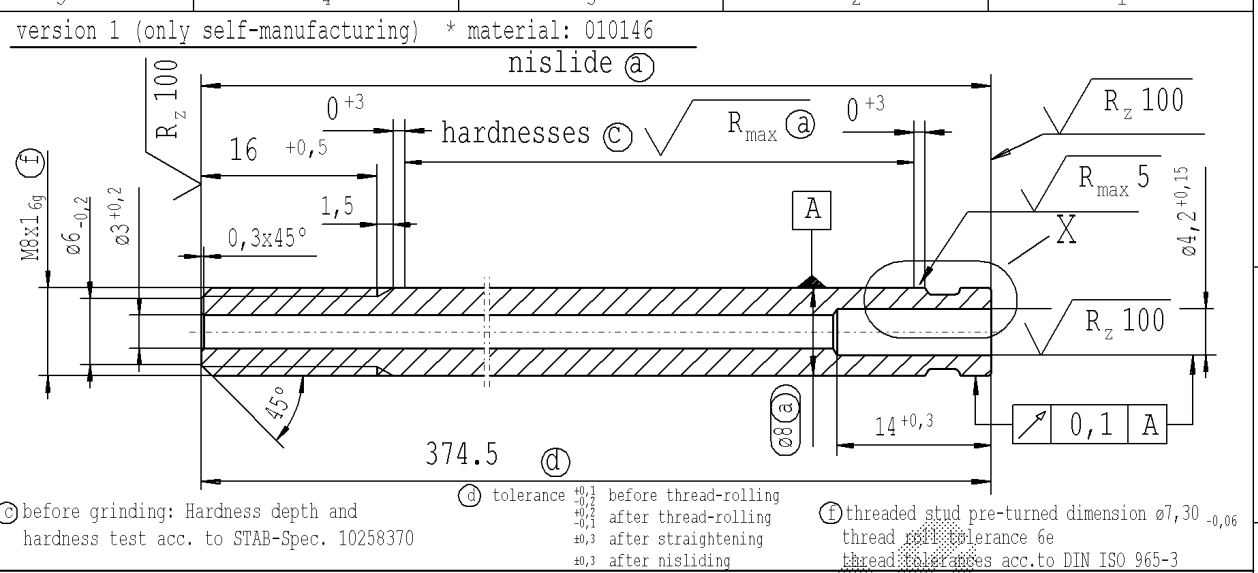
Ident. Doc.:

supp No.	material no.			A	B
	processing and surface treatment acc. to STAB-Spec.:			overall length	stud length end-fitting side
	10006248 Tab. IV	10006248 Tab. X	10028959 Tab. I		
	(a) version 1	(a) version 1	(b) version 2		
49	316963		316963	497.5	16
50	317919		317919	452.5	16
51	318397		318397	535.5	16
52			543060	374.5	16
53		647742	647742	569.5	18
54		481160	481160	512.5	22
55	481399		481399	577.5	20
56		481638	481638	224.5	8



① dim. before grinding at piston rod dia. 8,2±0,1

④ knurl-profile manuf. with knurl roll DIN 82 - RAA 0,5



100% cleanliness of through hole

Rz 25 (Rz 100 Rmax 5 Rmax (a) Ra (b) Rz (b))

sheet 4 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	marking groove removed			③ = acc. STAB-Spec. 10258370			100% cleanliness of through hole		Scale: (Original DIN A3) 2:1	Dimensions without tolerances DIN ISO 2768-mK	24.01.2008	Höfer	
old	-			④ = RHT 0,4 ... 0,7 mm			Permanent additional inspection 014/01	Edge tolerances acc. to DIN ISO 13715			Checked	25.06.2021	Klinkner
Field	-				C 7-8		B/5-6	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.				Document No.: 10152217
Date/Name	12.06.2014 Hein			15.05.2019 Donat			08.06.2021 Hein	Replaces:	<div style="text-align: center; font-size: 2em; font-weight: bold;">PISTON ROD</div>				Material No.:
Chg. No.	614235			678703			677895						
Rev.	5			6			7						
							8						