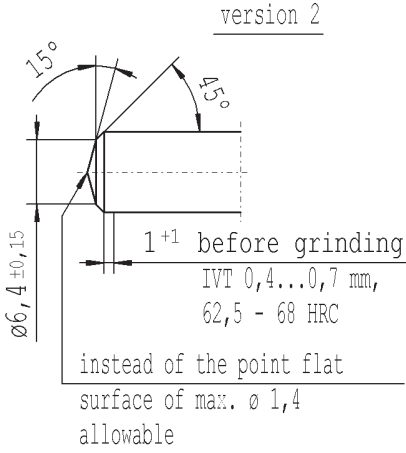
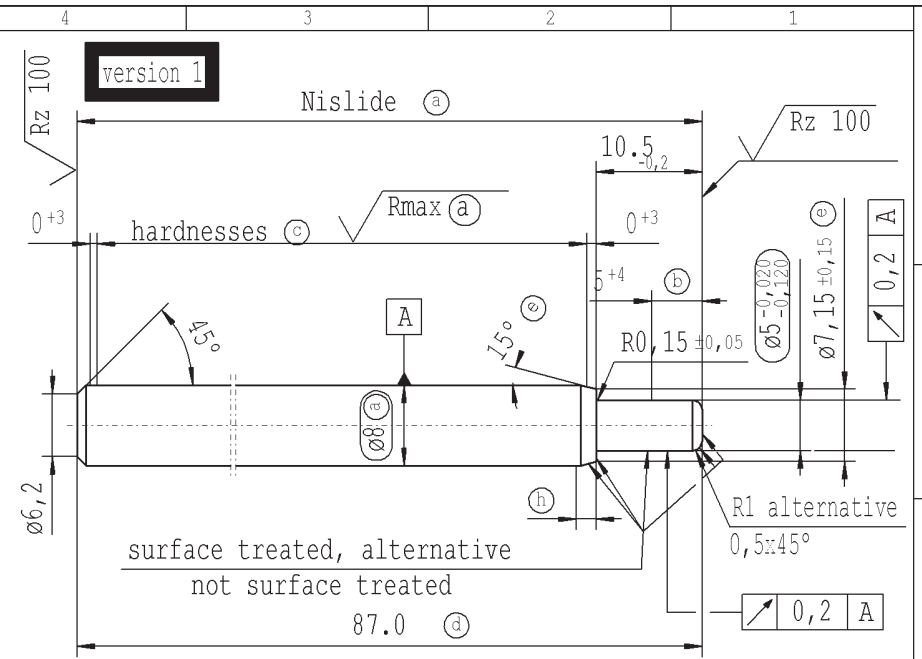


Ident. Doc.: SN 53.11-06/04/14:um: 13/05/2021 - 20:26

F	supp No.	material no.					A	B	F
		surface treatment processing acc. to STAB-Spec. 10006248							
		table IV Nislid black	table V Nislid light	table VIII Nislid black	table X Nislid "G"	table XVI Nislid black			
146	2214KM					2214KM	117.0	10.5	1
147	967297				967297		252.0	10.5	1
148	4579AI					4579AI	168.0	10.5	2
152	643270				643270		183.0	10.5	1
153	643319				643319		158.0	10.5	1
154	186201				186201		134.5	10.5	1
155	643327						107.0	10.5	1
156	866229						103.5	10.5	1
157	643211				643211		97.0	10.5	1
161	751944				751944		72.0	10.5	1
164	387266				387266		318.0	10.5	1
165	643343				643343		243.5	10.5	1
166	643254				643254		221.5	10.5	1
167	643238				643238		210.5	10.5	1
168	8002BD				8002BD		200.0	10.5	1
169	643300				643300		164.5	10.5	1
170	186554						167.5	10.5	1
172	9406HE						279.0	15.0	1
173	5942ME						118.5	10.5	1
175				6087MK			208.0	10.5	1
177				6097ME			448.5	10.5	1
179	6103MR						298.0	10.5	1
181	6839MB						256.0	10.5	1
184	7117MK				7117MK		115.5	11	1
189	0727NO				0727NO		154.0	10.5	1
191	0741NF				0741NF		435.0	10.5	1
195	0842NU				0842NU		87.0	10.5	1
197	0909NC				0909NC		126.0	10.5	1
199	1806NQ				1806NQ		148.0	10.5	1



- (a) piston rod processing acc. to STAB-Spec. 10006248  
for piston rods without surface treatment  
grinding dimension  $-0,046$   
 $-0,057$   
Rmax after grinding  $\leq 1,5 \mu\text{m}$
- (b) surface chrome-free
- (c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370
- (d) tolerances:  $\pm 0,1$  after turning  
 $\pm 0,3$  after straightening  
 $\pm 0,3$  after chroming/nisliding
- (e) assy. chamfer only for stud length 10,5 and 11,0 mm
- (h) max. 2 mm chrome-free qualified layer thickness, no test range

$\sqrt{Rz 25}$  ( $\sqrt{Rz 100}$   $\sqrt{Rmax (a)}$ )  $\swarrow +0,2$   $\searrow -0,2$  sheet 5 of 11

AIAG CQI-standards acc. to STAB-Spec. 10027692						Environmental protection acc. to STAB-Spec. 10005649						
DE: X	EN: X	ES: X	IT:	PR:	FR:	RO: X	CAD created document handwritten changes not permitted					
new	RI alternative 0,5x45°	chrome DDK 10214401	Tab.XVI	Creation of romanian drawing	© = acc. STAB-Spec. 10258370	Material: mat.no. 010731						
old	0,5x45° alternative RI	-	-	-	© = RHT 0,4 .... 0,7 mm	All dimensions are in mm						
Field	D-E/1	Pos 78,90,115,137,185	-	-	C 1-2	Identification of important characteristics						
Date/Name	19.03.2009 Hein	06 08 2014 Höfer	07.10.2015 Höfer	08.04.2016 YaMueller	08.05.2019 Jablonski	Scale: 2:1 (Original DIN A3)						
Chg. No.	571413	615932	629279	635494	678350	Dimensions without tolerances DIN ISO 2768-mK						
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						Replaces: Zchnng. gl. Nr. v. 01.07.1997						
						<b>STABILUS</b>						
						PISTON ROD						
						Date: 23.11.1999 Name: Mohrs						
						Checked: 08.05.2019 Milles						
						Document No.: 10003762						
						Material No.:						