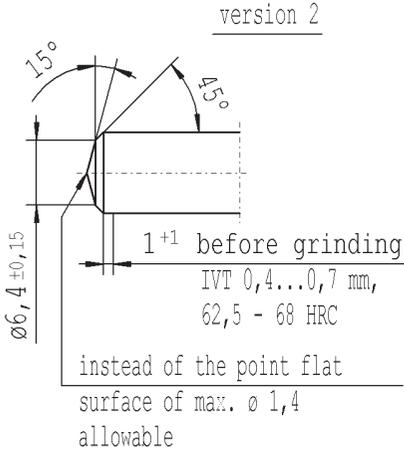
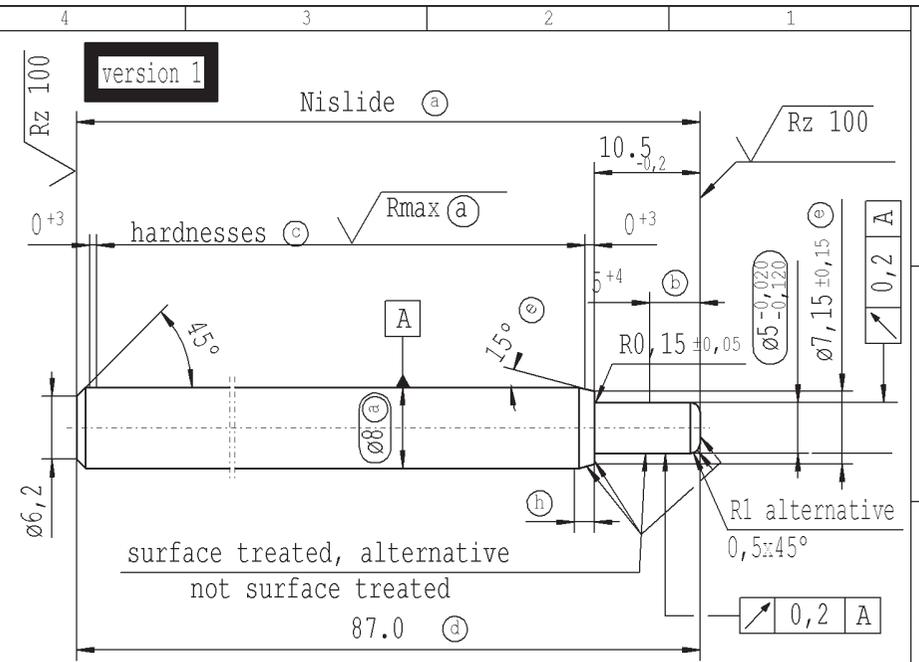
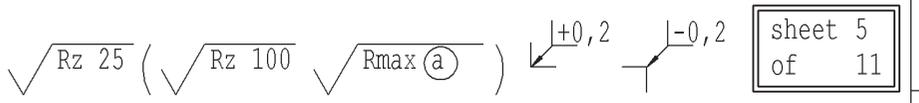


Ident. Doc.: SN 53.11-06/04/14:um: 13/05/2021 - 20:26

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



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		All dimensions are in mm		Identification of important characteristics		Date	Name
old	0,5x45° alternative RI	-	-	-	© = RHT 0,4 0,7 mm		Edge tolerances acc. to DIN ISO 13715		Scale: 2:1 (Original DIN A3)		Dimensions without tolerances DIN ISO 2768-mK		Drawn by	23.11.1999 Mohrs
Field	D-E/1	Pos 78,90,115,137,185	-	-	C 1-2		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.: 10003762		Checked	08.05.2019 Milles
Date/Name	19.03.2009 Hein	06 08 2014 Höfer	07.10.2015 Höfer	08.04.2016 YaMueller	08.05.2019 Jablonski		Replaces: Zchnng. gl. Nr. v. 01.07.1997		STABILUS		PISTON ROD		Material No.:	
Chg. No.	571413	615932	629279	635494	678350									
Rev.	47	48	49	50	51									