

Ident. Doc.:
Date: 13.02.2023 / 10:07:14
The print-out is not subject to the modification service.
Intended for internal and supplier use
EN

supp. No.	material no.			A	B
	processing and surface treatment acc. to STAB-Spec.: 10006248 Tab. IV 10006248 Tab. X 10028959 Tab. I			overall length	stud length end-fitting side
	(a) version 1	(a) version 1	(b) version 2		
145		925461	925461	169.5	16
146		925939	925939	143.5	22
147		926417	926417	128.5	16
148		926895	926895	134.5	16
149		927373	927373	248.5	16
150		927851	927851	68.5	16
151	928329		928329	473.5	18
152	928807		928807	509.5	18
153	058131		058131	503.5	18
154		211092	211092	407.5	20
155	356165		356165	569.5	18
156		183847	183847	394.5	16
157		299284	299284	275.5	20
158		310517	310517	377.5	20
159	325096		325096	515.5	20

X pre-worked:
(only self-manufacturing)

X Control dimension!
100 % visual checking

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

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

version 1 (only self-manufacturing) * material: 010146

nislide ①

③ before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370

④ tolerance $\begin{matrix} +0,1 \\ -0,2 \\ -0,1 \\ +0,3 \\ +0,3 \end{matrix}$ before thread-rolling after thread-rolling after straightening after nislide

⑤ threaded stud pre-turned dimension $\varnothing 7,30_{-0,06}$ thread roll tolerance 6e thread tolerances acc.to DIN ISO 965-3

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

nitrided ②

approved lengths: 60-630 mm approved lengths thread: 13-40 mm

100% cleanliness of through hole

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

sheet 10 of 10

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: *		
new	marking groove removed	③ = acc. STAB-Spec. 10258370		100% cleanliness of through hole		new format Internal/Supplier		All dimensions are in mm		Marking of special characteristics according to STAB-Spec. 10270932	
old	-	③ = RHT 0,4 0,7 mm		Permanent additional inspection 014/01		Supplier drawing separately		Scale: (Original DIN A3) 2:1		Dimensions without tolerances DIN ISO 2768-mK	
Field	-	C 7-8		B/5-6		-		Edge tolerances acc. to DIN ISO 13715		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		Surface finish DIN EN ISO 1302		Replaces:	
Chg. No.	614235	678703		677895		698589		Replaces:		Document No.: 10152217	
Rev.	5	6		7		8		Material No.:		PISTON ROD	