

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

Intended for internal and supplier use

EN

Ident. Doc.:

Date/Name

supp No.	material no.			A	B	D	E
	10006248 Tab. IV version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length	length without $\sqrt{R_{max}}$ without R_{z}	length without endfitting stud
1	226618		226618	264	14	22	250
2	242877		242877	213	12	22	201
3	407070		407070	402	20	22	382
4	407309		407309	666	10	10	656
5	728765		728765	162	14	22	148
6	729243		729243	564	14	22	550
7	735218		735218	462	14	22	448
8	741193		741193	312	14	22	298
9	741910		741910	210	14	10	196
10	742388		742388	465	14	22	451
11	744300		744300	153	14	22	139
12	745017		745017	124	14	22	110
13	745495		745495	315	14	22	301
14	748363		748363	591	14	22	577
15	748841		748841	363	14	22	349

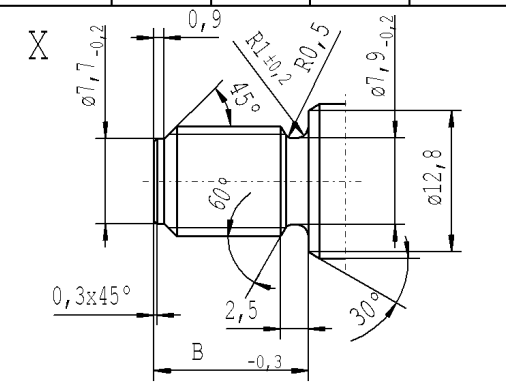
(c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370

(d) tolerances: +0,3 after turning;
+0,3 after straightening;
+0,3 after nisliding

(e) threaded stud rough-turned dim. $\phi 8,97_{-0,06}$
thread roll tolerance 6e
thread tolerances acc. to DIN ISO 965-3

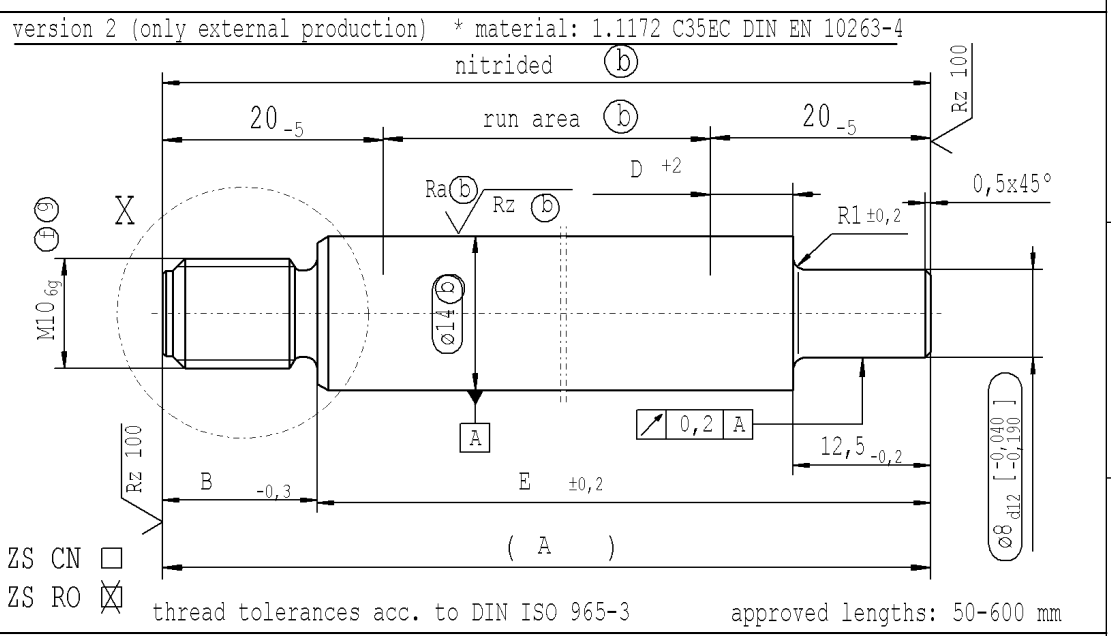
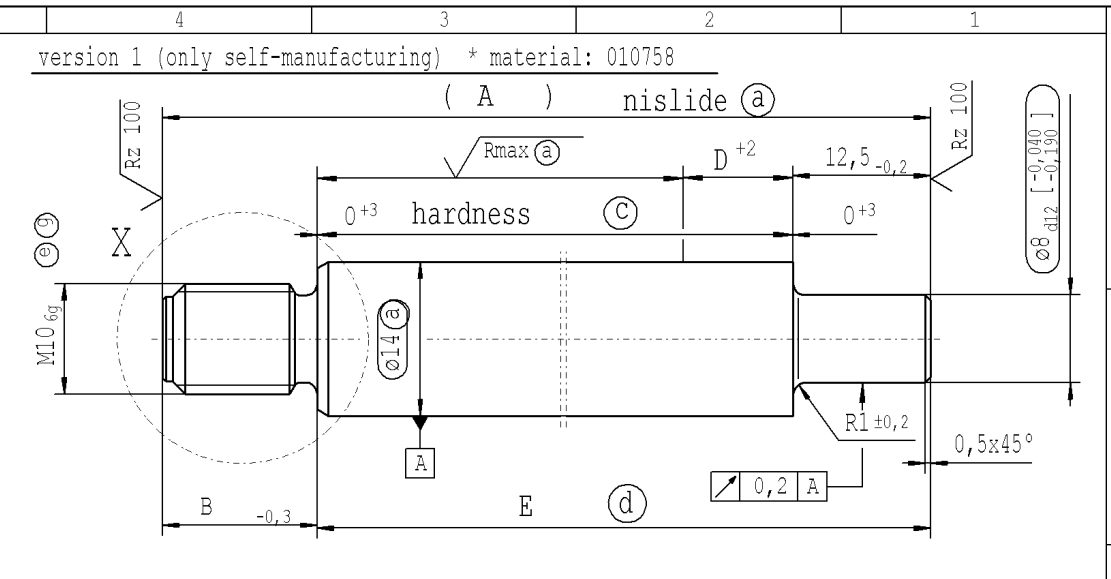
(f) rough-turned dim. thread roll tolerance 6e

(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



Caution!
for twin-seal dim. $D=10^{+2}$

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	© = acc. STAB-Spec. 10258370		new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g (f) (g)				Scale: (Original DIN A3) 2:1		Dimensions without tolerances DIN ISO 2768 mK		Drawn by	02.01.2008 Höfer
old	© = RHT 0,4 ... 0,7 mm		Supplier drawing separately		1.1193 S45C JISG 4051		-				Edge tolerances acc. to DIN ISO 13715				Checked	25.04.2022 Klinkner
Field	C 4-5		-		D/1-2		B-F/4-5; B/7-8				Surface finish DIN EN ISO 1302				Document No.:	
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein				Replaces:				10151648	
Chg. No.	678703		689534		706933		709668								Material No.:	
Rev.	5		6		7		8									



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

sheet 1 of 7

AIAG CQI-standards acc. to STAB-Spec. 10027692		Environmental protection acc. to STAB-Spec. 10005649	
DE: X	EN: X	ES:	IT:
new	© = acc. STAB-Spec. 10258370		new Format Internal/Supplier
old	© = RHT 0,4 ... 0,7 mm		Supplier drawing separately
Field	C 4-5		-
Date/Name	15.05.2019 Donat		25.06.2020 Höfer
Chg. No.	678703		689534
Rev.	5		6

STABILUS

PISTON ROD

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EN

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supp. No.	material no.			A	B	D	E
	10006248 Tab. IV version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length	length without $\sqrt{R_{max}}$ without R_{z}	length without endfitting stud
16	749558		749558	213	14	22	199
17	750036		750036	396	14	22	382
18	750753		750753	288	12	22	276
19	755055		755055	414	14	22	400
20	756489		756489	165	14	10	151
21	757923		757923	516	14	10	502
22	758401		758401	165	14	22	151
23	759357		759357	507	14	22	493
24	759835		759835	231	14	22	217
25	762464		762464	192	14	10	178
26	762942		762942	369	14	22	355
27	763420		763420	546	14	22	532
28	764137		764137	141	14	22	127
29	764854		764854	411	14	22	397
30	765332		765332	267	14	22	253

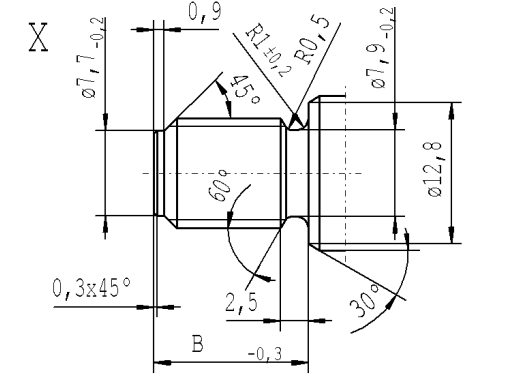
(c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370

(d) tolerances: $+0,3$ after turning;
 $+0,3$ after straightening;
 $+0,3$ after nisliding

(e) threaded stud rough-turned dim. $\varnothing 8,97_{-0,06}$
thread roll tolerance 6e
thread tolerances acc. to DIN ISO 965-3

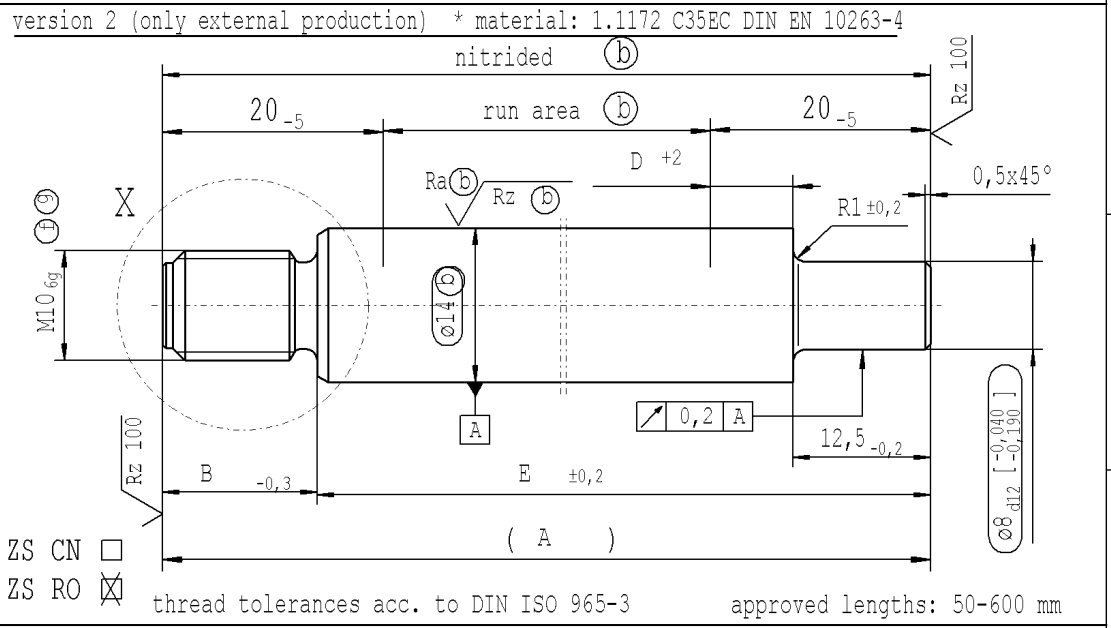
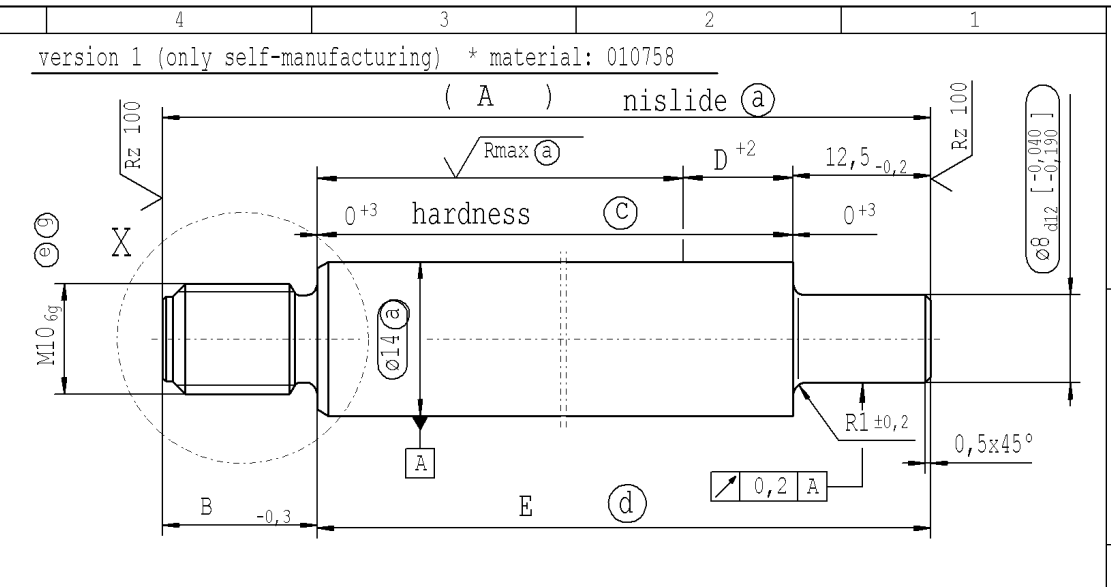
(f) rough-turned dim. thread roll tolerance 6e

(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



Caution!
for twin-seal dim. $D=10^{+2}$

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
new	(c) = acc. STAB-Spec. 10258370	new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g (f) (g)	Material: *
old	(c) = RHT 0,4 ... 0,7 mm	Supplier drawing separately		1.1193 S45C JISG 4051		-	All dimensions are in mm
Field	C 4-5		-	D/1-2		B-F/4-5; B/7-8	Marking of special characteristics according to STAB-Spec. 10270932
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein
Chg. No.	678703		689534		706933		709668
Rev.	5		6		7		8



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

sheet 2 of 7

Material: *	All dimensions are in mm	Date	Name	
	Scale: (Original DIN A3) 2:1			Drawn by
Edge tolerances acc. to DIN ISO 13715	Marking of special characteristics according to STAB-Spec. 10270932	Checked	25.04.2022	Klinkner
Surface finish DIN EN ISO 1302	Dimensions without tolerances DIN ISO 2768 mK	Document No.:	10151648	
Replaces:	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.	Material No.:		
STABILUS	PISTON ROD			

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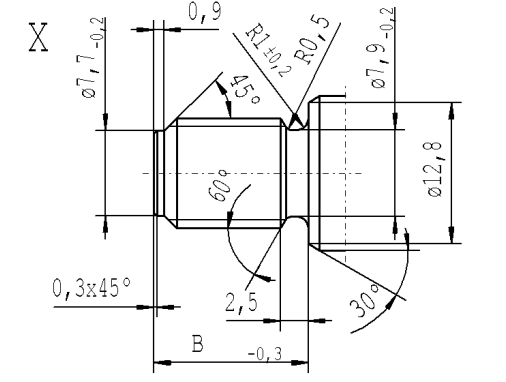
EN

Ident. Doc.:

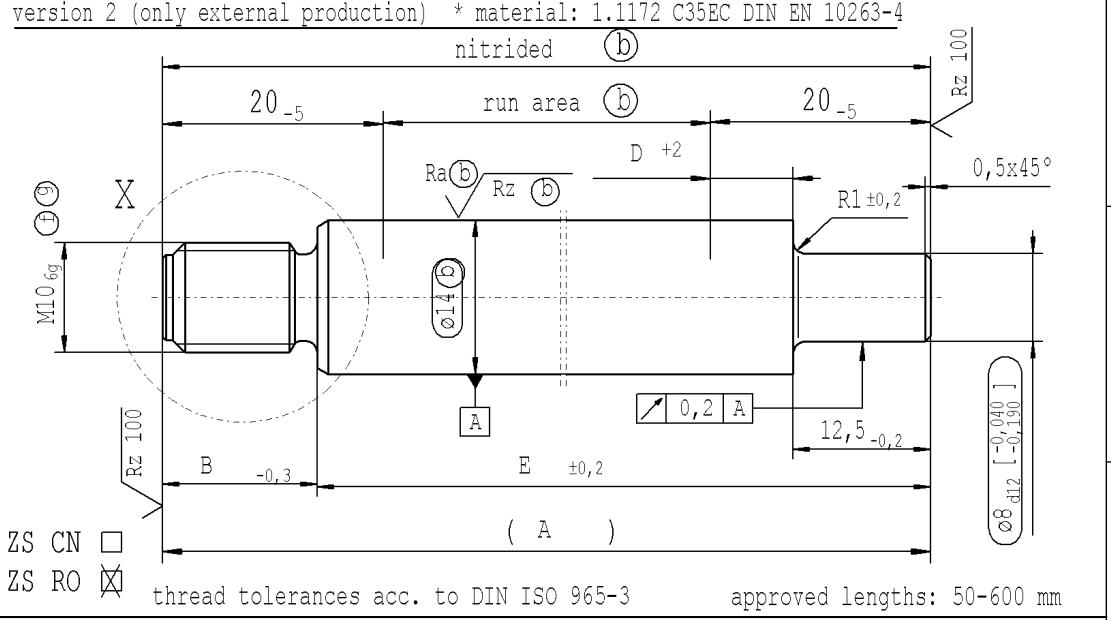
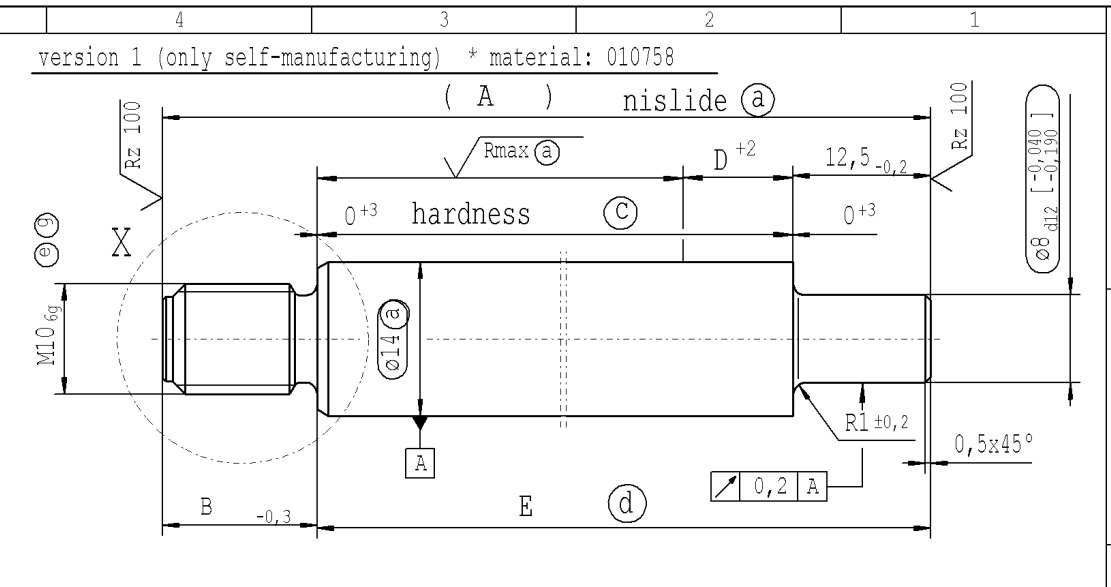
Date/Name

supp. No.	material no.			A	B	D	E
	10006248 Tab. IV version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length	length without $\sqrt{R_{max}}$ without $R_{a(2)}$ R_z \textcircled{D}	length without endfitting stud
31	765810		765810	225	14	22	211
32	770112		770112	273	12	22	261
33	770829		770829	192	14	22	178
34	771307		771307	153	12	22	141
35	771785		771785	138	14	22	124
36	772263		772263	324	14	22	310
37	772741		772741	345	14	10	331
38	773219		773219	159	12	22	147
39	773936		773936	216	14	22	202
40	775131		775131	366	14	22	352
41	775848		775848	162	12	22	150
42	777043		777043	135	14	22	121
43	778716		778716	267	14	10	253
44	779194		779194	288	14	22	274
45	779672		779672	366	14	10	352

- \textcircled{C} before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370
- \textcircled{D} tolerances: $+0,3$ after turning;
 $+0,3$ after straightening;
 $+0,3$ after nisliding
- \textcircled{E} threaded stud rough-turned dim. $\varnothing 8,97_{-0,06}$
thread roll tolerance 6e
thread tolerances acc. to DIN ISO 965-3
- \textcircled{F} rough-turned dim. thread roll tolerance 6e
- \textcircled{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



Caution!
for twin-seal dim. $D=10^{+2}$



$\sqrt{R_z 25}$ ($\sqrt{R_z 100}$ $\sqrt{R_{max} \textcircled{A}}$ $R_a \textcircled{B}$ $R_z \textcircled{B}$) $\begin{matrix} +0,2 \\ -0,1 \end{matrix}$ $\begin{matrix} +0,2 \\ -0,2 \end{matrix}$

sheet 3 of 7

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
new	\textcircled{C} = acc. STAB-Spec. 10258370	new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g \textcircled{F} \textcircled{G}	
old	\textcircled{C} = RHT 0,4 ... 0,7 mm	Supplier drawing separately		1.1193 S45C JISG 4051		-	
Field	C 4-5		-		D/1-2		B-F/4-5; B/7-8
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein
Chg. No.	678703		689534		706933		709668
Rev.	5		6		7		8
Material: *				All dimensions are in mm			
Edge tolerances acc. to DIN ISO 13715				Marking of special characteristics according to STAB-Spec. 10270932			
Surface finish DIN EN ISO 1302				Scale: (Original DIN A3) 2:1			
Replaces:				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.			
STABILUS				PISTON ROD			
Date/Name				Date		Name	
25.04.2022				02.01.2008		Höfer	
Document No.:				10151648			
Material No.:							

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Ident. Doc.:

supp No.	material no.			A	B	D	E
	10006248 Tab. IV version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length	length without $\sqrt{R_{max}}$ without R_{z}	length without endfitting stud
46	780867		780867	159	14	22	145
47	781823		781823	318	14	10	304
48	782779		782779	150	14	22	136
49	783496		783496	216	14	10	202
50	784213		784213	315	14	10	301
51	784691		784691	465	14	10	451
52	785408		785408	417	14	22	403
53	785886		785886	189	14	22	175
54	786603		786603	564	14	10	550
55	790905		790905	213	14	10	199
56	791383		791383	168	14	22	154
57	791861		791861	432	14	10	418
58	792817		792817	363	14	10	349
59	793295		793295	198	14	22	184
60	793773		793773	249	14	22	235

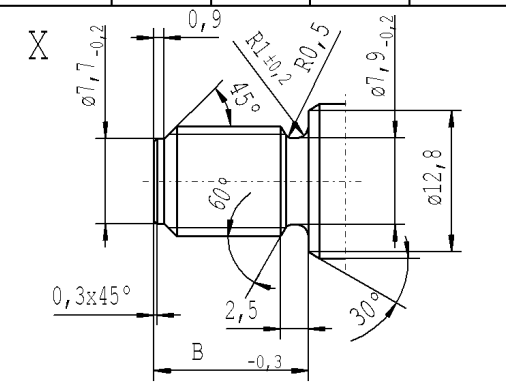
(c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370

(d) tolerances: $+0,3$ after turning;
 $+0,3$ after straightening;
 $+0,3$ after nisliding

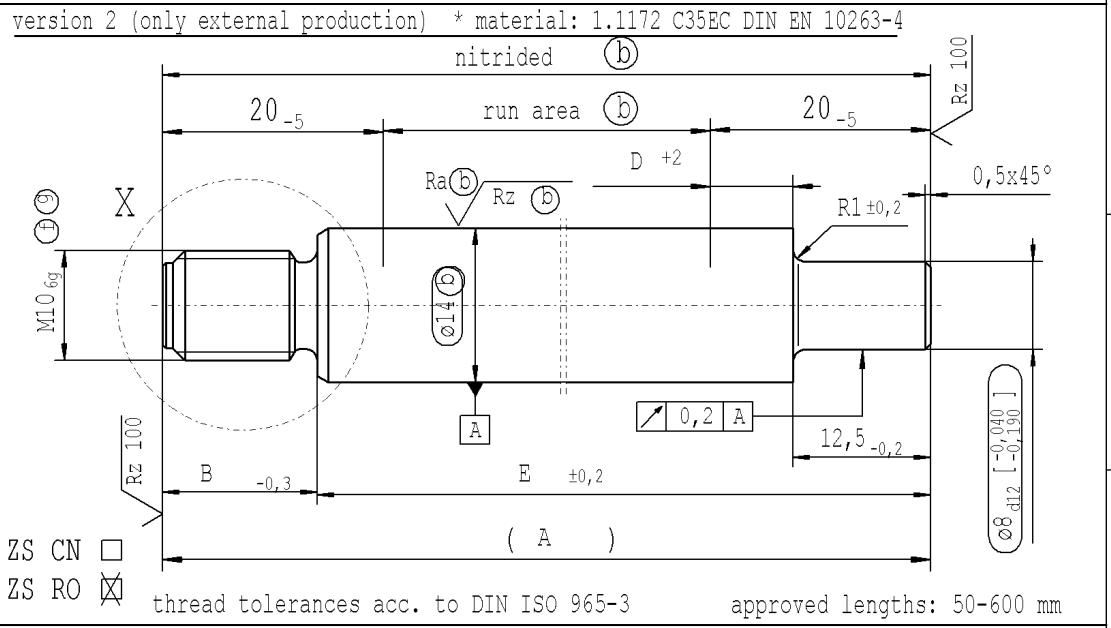
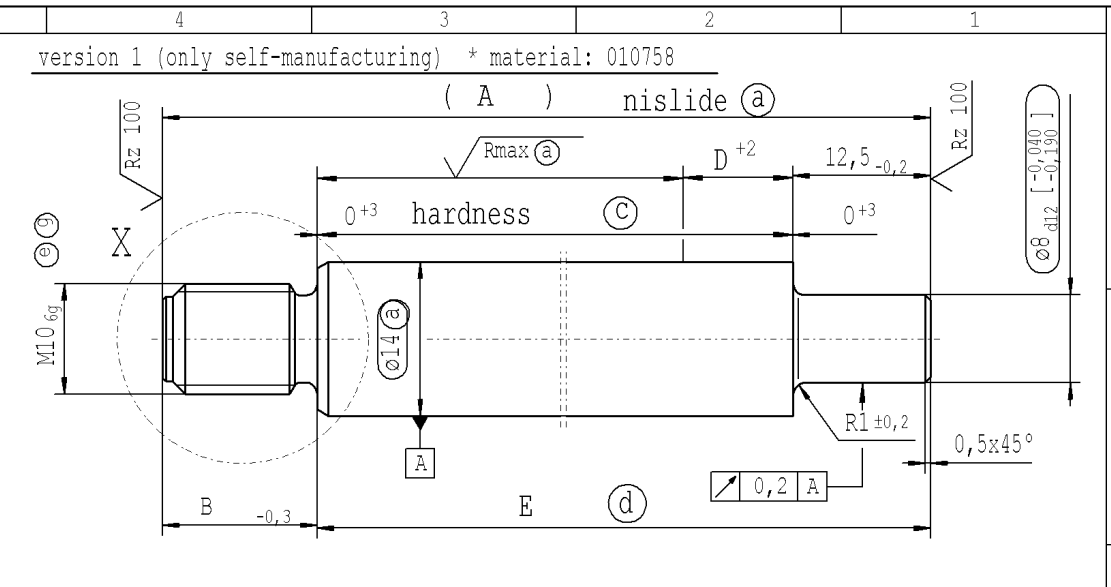
(e) threaded stud rough-turned dim. $\varnothing 8,97_{-0,06}$
thread roll tolerance 6e
thread tolerances acc. to DIN ISO 965-3

(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



Caution!
for twin-seal dim. $D=10^{+2}$



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

sheet 4 of 7

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
new	© = acc. STAB-Spec. 10258370		new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g (f) (g)
old	© = RHT 0,4 ... 0,7 mm		Supplier drawing separately		1.1193 S45C JISG 4051		-
Field	C 4-5		-		D/1-2		B-F/4-5; B/7-8
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein
Chg. No.	678703		689534		706933		709668
Rev.	5		6		7		8
Material: *				All dimensions are in mm			
Edge tolerances acc. to DIN ISO 13715				Marking of special characteristics according to STAB-Spec. 10270932			
Surface finish DIN EN ISO 1302				Scale: (Original DIN A3) 2:1			
Replaces:				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.			
STABILUS				PISTON ROD			
Date				Date		Name	
Drawn by				Date		Name	
Checked				Date		Name	
Document No.:				10151648			
Material No.:							

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Ident. Doc.:

Date/Name

supp. No.	material no.			A	B	D	E
	10006248 Tab. IV version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length	length without $\sqrt{R_{max}}$ without R_{z}	length without endfitting stud
61	795446		795446	567	12	10	555
62	795924		795924	366	12	10	354
63	796402		796402	300	14	10	286
64	803333		803333	243	14	22	229
65	803811		803811	206	14	22	192
66	804767		804767	345	14	22	331
67	806440		806440	459	14	10	445
68	806918		806918	230	14	22	216
69	807396		807396	240	14	10	226
70	809786		809786	276	14	22	262
71	810264		810264	336	14	22	322
72	810742		810742	279	14	22	265
73	811698		811698	264	14	10	250
74	812176		812176	246	14	10	232
75	813132		813132	114	14	22	100

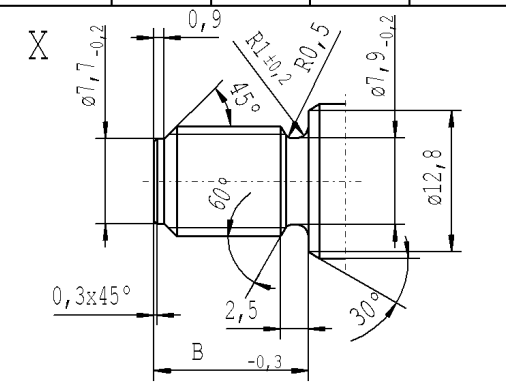
(c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370

(d) tolerances: +0,3 after turning;
+0,3 after straightening;
+0,3 after nisliding

(e) threaded stud rough-turned dim. $\varnothing 8,97_{-0,06}$
thread roll tolerance 6e
thread tolerances acc. to DIN ISO 965-3

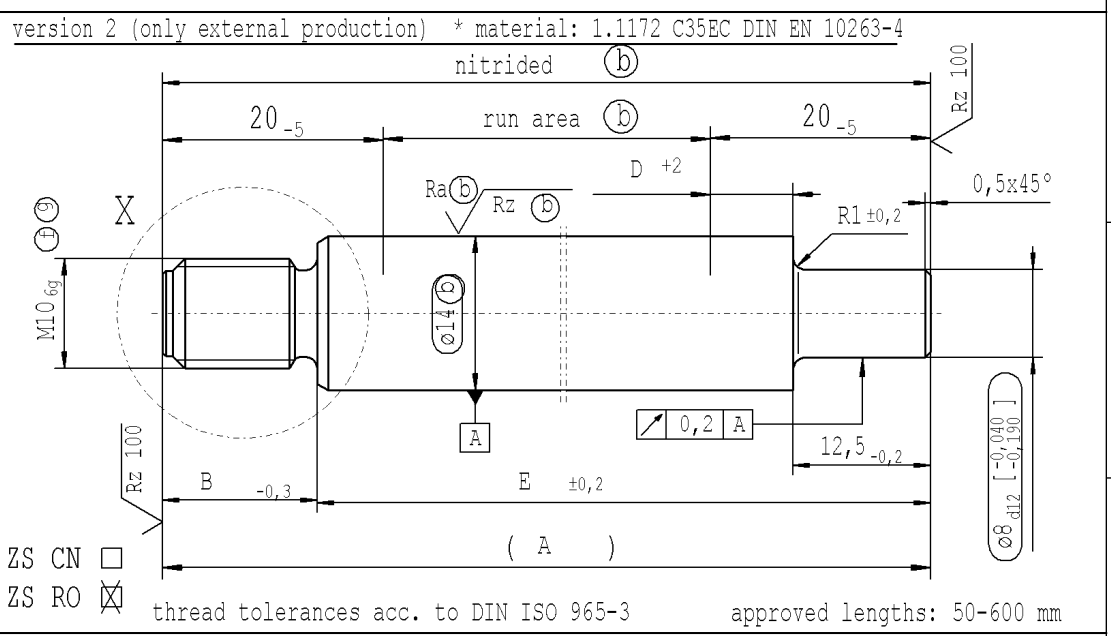
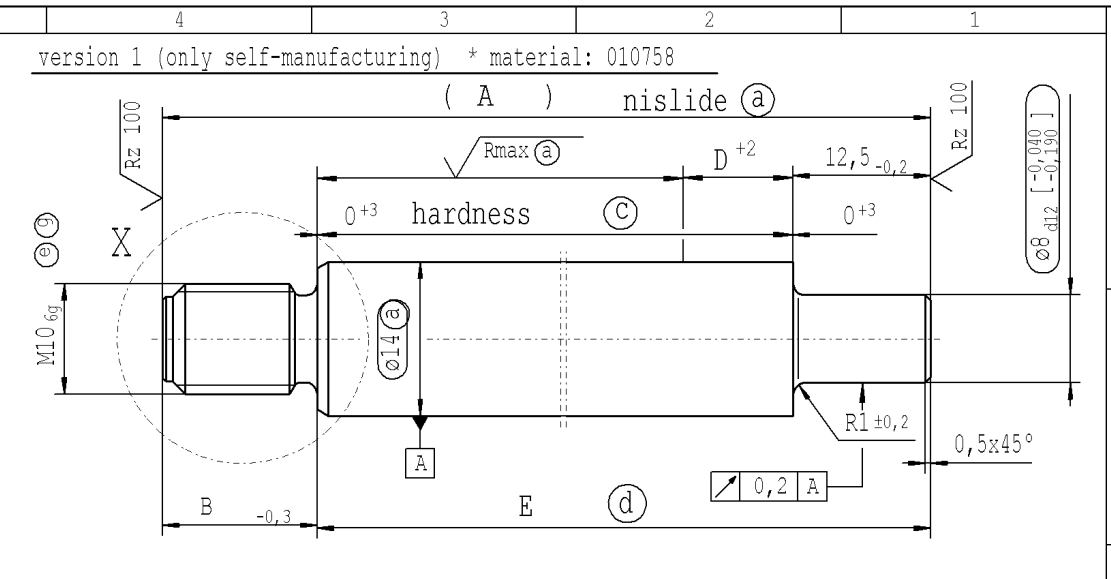
(f) rough-turned dim. thread roll tolerance 6e

(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



Caution!
for twin-seal dim. $D=10^{+2}$

DE: X		EN: X	ES:	IT:	PR:	FR:	RO: X	CAD created document; handwritten changes not permitted	
new	© = acc. STAB-Spec. 10258370		new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g (f) (g)		
old	© = RHT 0,4 ... 0,7 mm		Supplier drawing separately		1.1193 S45C JISG 4051		-		
Field	C 4-5		-		D/1-2		B-F/4-5; B/7-8		
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein		
Chg. No.	678703		689534		706933		709668		
Rev.	5		6		7		8		



$\sqrt{Rz\ 25}$ ($\sqrt{Rz\ 100}$ $\sqrt{R_{max}}$ (a) Ra (b) Rz (b)) $\begin{matrix} +0,2 \\ \swarrow \\ +0,1 \end{matrix}$ $\begin{matrix} -0,2 \\ \searrow \end{matrix}$

sheet 5 of 7

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	Material: *	All dimensions are in mm	Marking of special characteristics according to STAB-Spec. 10270932	Date	Name
new	© = acc. STAB-Spec. 10258370		new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g (f) (g)	Scale: (Original DIN A3) 2:1	Dimensions without tolerances DIN ISO 2768 mK	Drawn by	02.01.2008 Höfer
old	© = RHT 0,4 ... 0,7 mm		Supplier drawing separately		1.1193 S45C JISG 4051		-	Edge tolerances acc. to DIN ISO 13715		Checked	25.04.2022 Klinkner
Field	C 4-5		-		D/1-2		B-F/4-5; B/7-8		Document No.: 10151648		
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein		Material No.:		
Chg. No.	678703		689534		706933		709668				
Rev.	5		6		7		8				

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Date/Name

supp No.	material no.			A	B	D	E
	10006248 Tab. IV version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length	length without $\sqrt{R_{max}}$ without R_{z}	length without endfitting stud
76	813610		813610	183	12	10	171
77	814088		814088	186	12	22	174
78	814566		814566	273	14	22	259
79	815044		815044	456	14	10	442
80	815522		815522	225	20	22	205
81	739043		739043	225	14	10	211
82	119317		119317	492	14	22	478
83	128160		128160	144	14	22	130
84	131028		131028	195	14	22	181
85	134613		134613	567	14	22	553
86	135091		135091	318	14	22	304
87	135569		135569	105	14	22	91
88	143456		143456	462	12	22	450
89	143934		143934	354	14	22	340
90	144412		144412	270	14	22	256

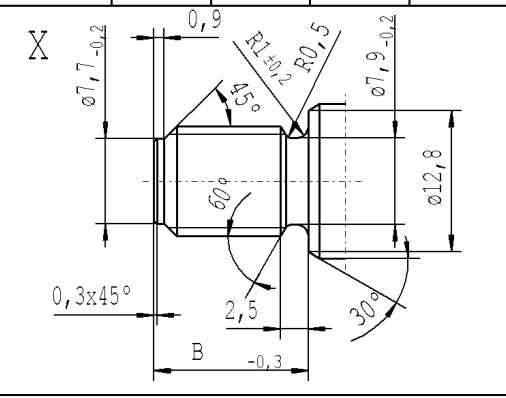
(c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370

(d) tolerances: $+0,3$ after turning;
 $+0,3$ after straightening;
 $+0,3$ after nisliding

(e) threaded stud rough-turned dim. $\varnothing 8,97_{-0,06}$
thread roll tolerance 6e
thread tolerances acc. to DIN ISO 965-3

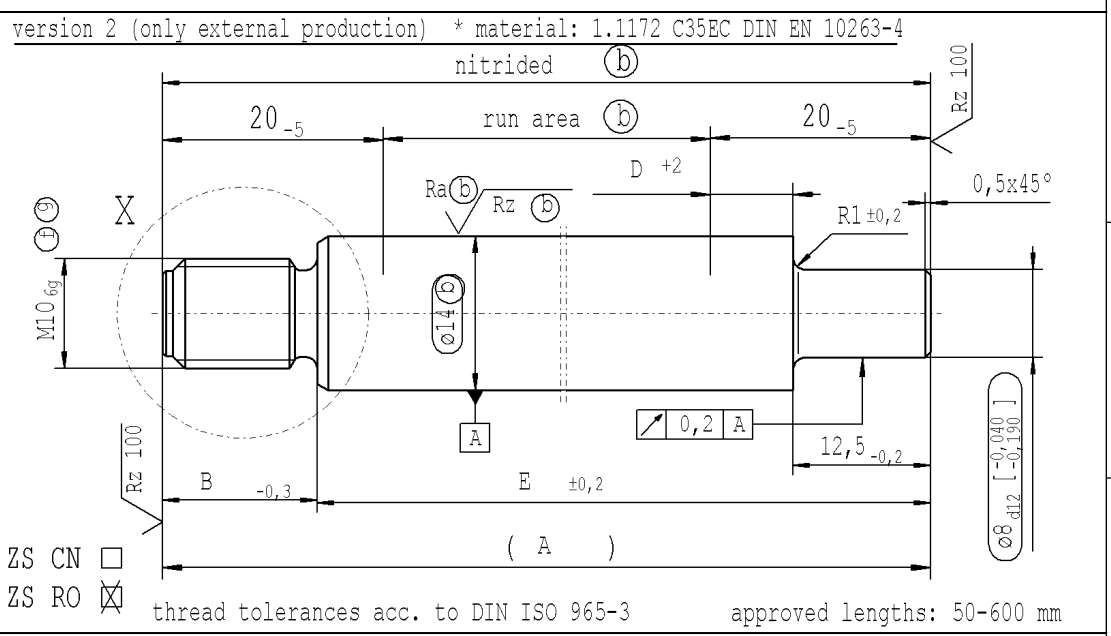
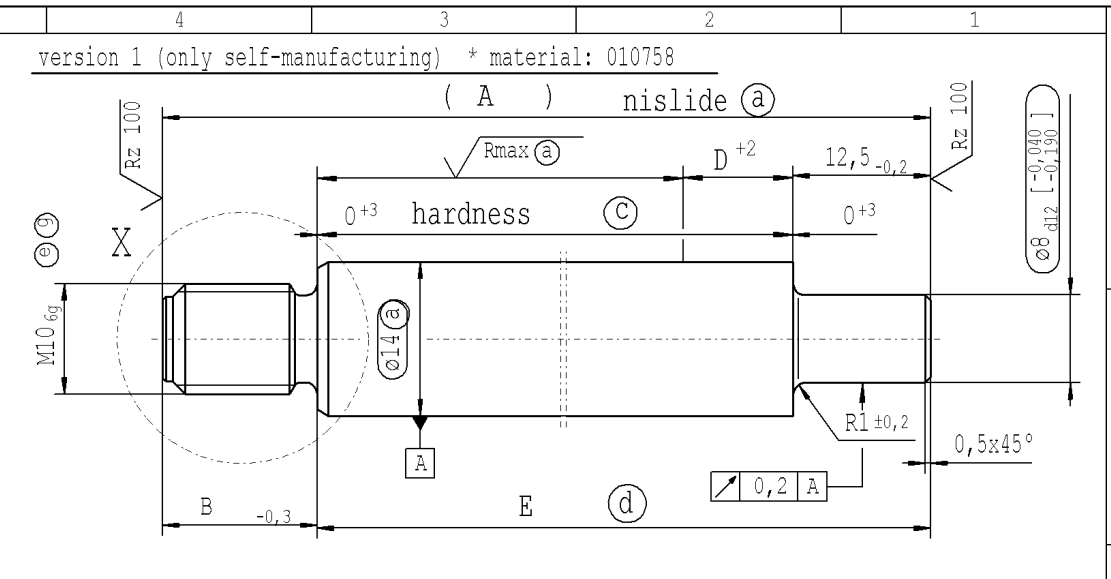
(f) rough-turned dim. thread roll tolerance 6e

(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



Caution!
for twin-seal dim. $D=10^{+2}$

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	© = acc. STAB-Spec. 10258370		new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g (f) (g)				Scale: (Original DIN A3) 2:1		Dimensions without tolerances DIN ISO 2768 mK		Drawn by	02.01.2008	Höfer
old	© = RHT 0,4 ... 0,7 mm		Supplier drawing separately		1.1193 S45C JISG 4051		-				Edge tolerances acc. to DIN ISO 13715				Checked	25.04.2022	Klinkner
Field	C 4-5		-		D/1-2		B-F/4-5; B/7-8				Surface finish DIN EN ISO 1302				Document No.:		10151648
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein				Replaces:				Material No.:		
Chg. No.	678703		689534		706933		709668				Replaces:						
Rev.	5		6		7		8				Replaces:						



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

sheet 6 of 7

AIAG CQI-standards acc. to STAB-Spec. 10027692		Environmental protection acc. to STAB-Spec. 10005649	
DE: X	EN: X	ES:	IT:
new	© = acc. STAB-Spec. 10258370		new Format Internal/Supplier
old	© = RHT 0,4 ... 0,7 mm		Supplier drawing separately
Field	C 4-5		-
Date/Name	15.05.2019 Donat		25.06.2020 Höfer
Chg. No.	678703		689534
Rev.	5		6

STABILUS

PISTON ROD

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

Intended for internal and supplier use

EN

Ident. Doc.:

Date/Name

supp. No.	material no.			A	B	D	E
	10006248 Tab. IV version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length	length without $\sqrt{R_{max}}$	length without endfitting stud
91	144890		144890	141	14	10	127
92	146324		146324	180	14	22	166
93	147280		147280	180	14	10	166
94	153255		153255	147	10	22	137
95	158991		158991	228	14	22	214
96	159947		159947	117	14	22	103
97	160425		160425	405	14	22	391
98	162098		162098	204	14	22	190
99	395362		395362	114	12	22	102

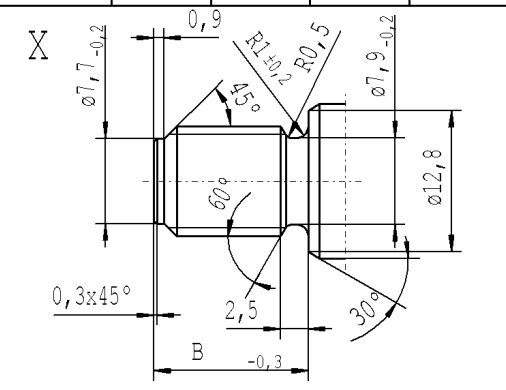
(c) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370

(d) tolerances: $+0,3$ after turning;
 $+0,3$ after straightening;
 $+0,3$ after nisliding

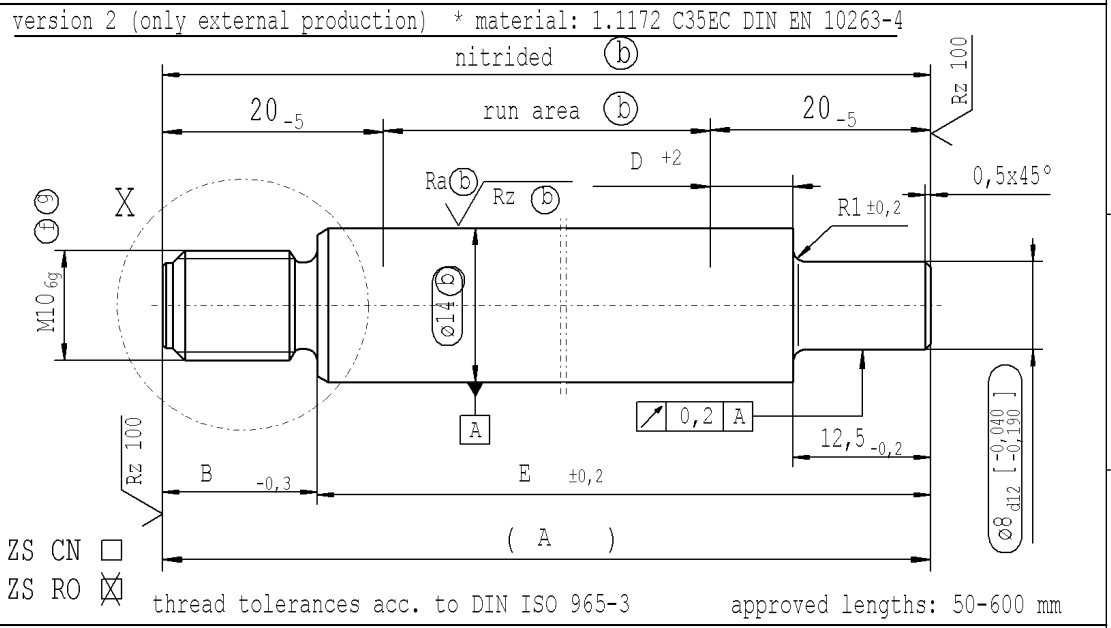
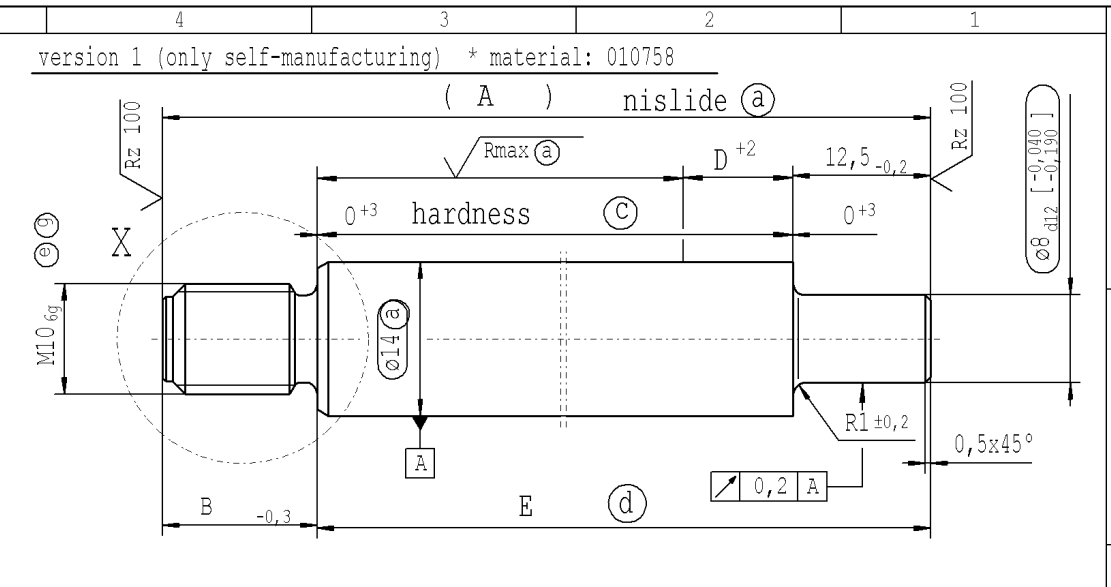
(e) threaded stud rough-turned dim. $\varnothing 8,97_{-0,06}$
thread roll tolerance 6e
thread tolerances acc. to DIN ISO 965-3

(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



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for twin-seal dim. $D=10^{+2}$



$\sqrt{Rz\ 25}$ ($\sqrt{Rz\ 100}$ $\sqrt{R_{max}}$ (a) Ra (b) Rz (b)) $\begin{matrix} +0,2 \\ \downarrow \\ +0,1 \end{matrix}$ $\begin{matrix} -0,2 \\ \downarrow \end{matrix}$

sheet 7 of 7

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
new	C = acc. STAB-Spec. 10258370		new Format Internal/Supplier		1.1172 C35EC DIN EN 10263-4		ZS CN / ZS RO; M10 6g (f) (g)
old	C = RHT 0,4 ... 0,7 mm		Supplier drawing separately		1.1193 S45C JISG 4051		-
Field	C 4-5		-		D/1-2		B-F/4-5; B/7-8
Date/Name	15.05.2019 Donat		25.06.2020 Höfer		15.02.2022 Hein		25.04.2022 Hein
Chg. No.	678703		689534		706933		709668
Rev.	5		6		7		8
Material: *				All dimensions are in mm			
Edge tolerances acc. to DIN ISO 13715				Marking of special characteristics according to STAB-Spec. 10270932			
Surface finish DIN EN ISO 1302				Scale: (Original DIN A3) 2:1			
Replaces:				Dimensions without tolerances DIN ISO 2768 mK			
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PISTON ROD				Date: 02.01.2008 Name: Höfer			
				Checked: 25.04.2022 Klinkner			
				Document No.: 10151648			
				Material No.:			