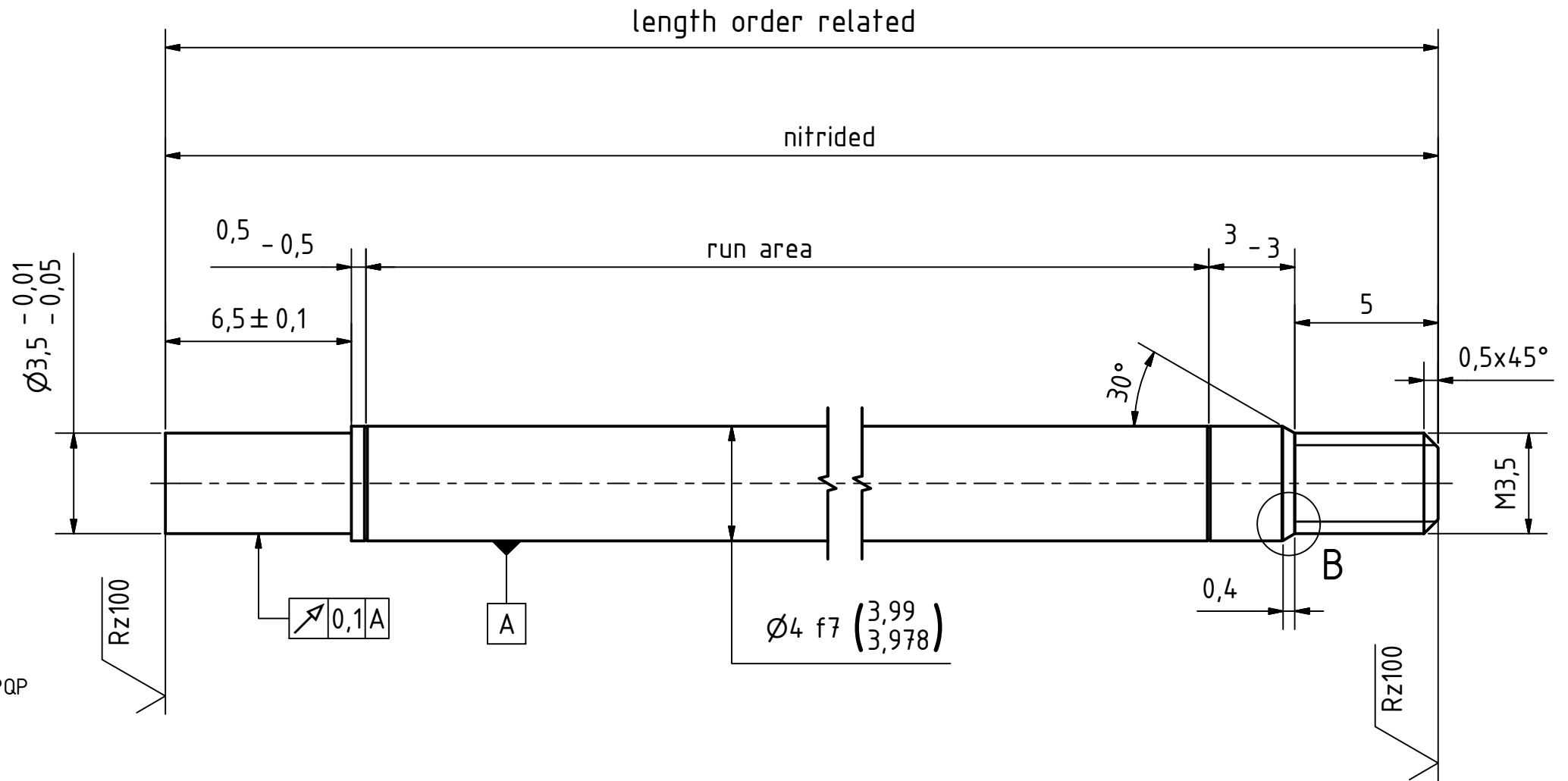


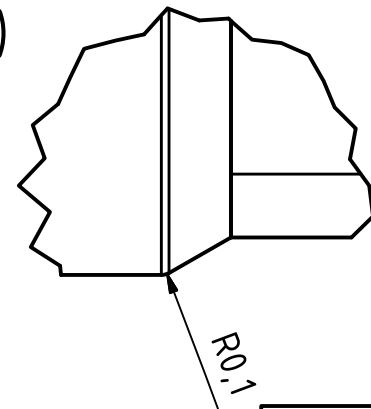
Color: brown/black
 1.) Bond zone: = 12 +10 µm
 2.) Porous zone: 2-8 µm

Surface treatment
 Surface processing of piston rods < 800mm length according to QPQP
 - process Surface hardness ≥ 430 HV 0,1 DIN EN ISO 6507-1
 Corrosion resistance: 144 h NSS DIN EN ISO 9227

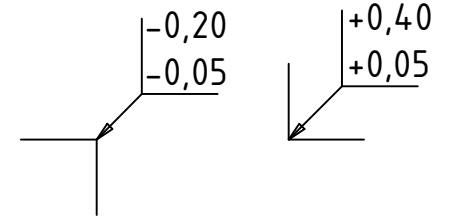
Piston rod free from cracks,
 guaranteed by optical individual test or eddy current test



B (20 : 1)



Rz25 (✓)



| Fertigmaß [mm] Finished dimension [mm] | | | Rauheit nach dem letzten Arbeitsschritt roughness depth after final condition | |
|--|-----|------|--|--|
| | | | | |
| zulässige Unrundheit permissible runout | | | Laufbereich run area | kein Laufbereich no run area |
| X | l1 | l | Ra = 0,06-0,1 µm Rz = ≤ 0,90 µm Rmr (TP) 50-70 % C = 25µm, 5% | Ra ≤ 0,20 µm Rz ≤ 1,5 µm Rmr (TP) 50-70% C = 25µm, 5% |
| 0,05 | 50 | >55 | | |
| 0,10 | 100 | >105 | | |
| 0,20 | 150 | >155 | | |
| 0,30 | 225 | >230 | | |

Diese Zeichnung ist ausschließlich unser Eigentum. Ohne unsere Zustimmung darf sie nicht vervielfältigt, dritten Personen mitgeteilt oder anderweitig benutzt werden.
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| | | | |
|-------------------|-------------------|------------------|------------|
| STAB Material No: | STAB Document No: | Maßstab Scale | 5:1 |
| | | Datum / Date | Name |
| | | 04.05.2023 | UGneiting |
| | | Checked | 04.05.2023 |
| | | Checked QS | |
| | | Checked Fert. | |
| | | | |
| Replaced by: | | Replacement for: | |

| | | | |
|---------------------------------|-----------------------------|----------------------------------|------------------------------|
| General-tolerance ISO 2768-m | Edge-tolerances DIN 6784 | Allgemein-Toleranz ISO 2768-m | Werkstück-kanten DIN 6784 |
| Art.-Nr.: | | Halbzg.-Nr. / Wrought mat: | |
| Material: S45C | | | |
| Gewicht / Weight: 0,016 kg | | | |
| Kolbenstange | | | |
| KST Ø4 M3,5x5; Nz 3,5x6,5 L= | | | |
| nach Auftrag | | | |
| Description: | | | |
| RD-00003217-1 | | | 1 A3 |
| Mod Nr.: RD-00003217-1 | | | |