

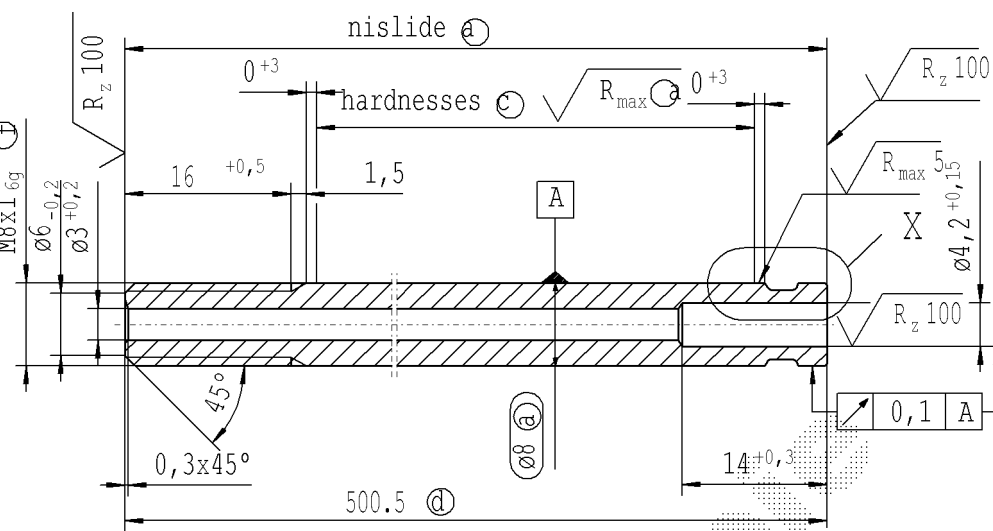
CONFIDENTIAL!
Intended for internal use only

supp. No.	material no.				A	B
	surface treatment processing acc. to STAB-Spec. 10006248					
	table IV Nislide black	table VIII Nislide black	table V Nislide light	table X Nislide "G"		
77	9405YW				491.5	16
79				9926IH	182.5	16
80				9942IP	410.5	16
81				0165KA	350.5	16
82				4817KU	110.0	13
83				0777LT	263.5	16
84				0285MA	86.5	16
86	5192MD	5624MA			500.5	16
88				9283MT	326.5	16
93				6397SN	317.5	16
94				4025TR	63.0	16
95				4687TK	173.5	16
96				8606UA	85.0	22
98		6833VW			470.5	16
99				5685VE	131.5	16
100				7769VA	365.5	16
104				8696YL	197.5	16
105				9159YU	311.5	16
107				2516ZC	341.5	16
110	3495ZM				625.5	16
111				3855ZI	146.5	16

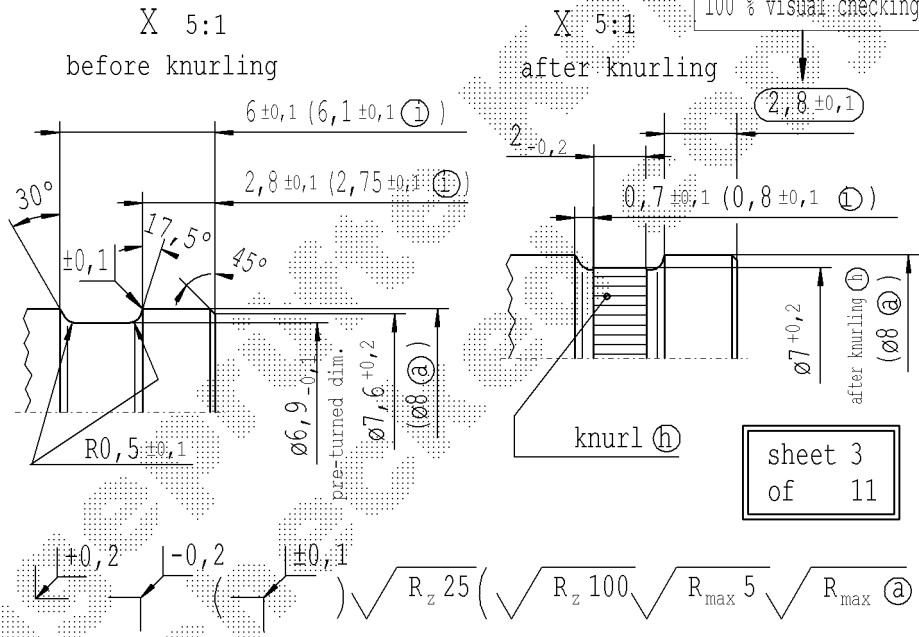
Permanent additional inspection 008/13
valid only for w/* marked Material No.

STBE	STES	STGB	STIT	STAU	STUS	STVZ	STWZ	STXZ	STYR	STZK
x										

100% Check concentricity thread M8x1
Test equipment coil cradle with dial gauge
! Caution using flat peak measuring!
Concentricity tolerance:
acc. to DIN ISO 2768-mK > 0,2 mm



100% cleanliness of through hole



Control dimension!
100 % visual checking

sheet 3
of 11

- a) piston rod processing per STAB-Spec. 10006248
- b) before grinding: Hardness depth and hardness test acc. to STAB-Spec. 10258370
- c) tolerance: +0,1 before thread-rolling, -0,2 after thread-rolling, +0,3 after straightening, +0,3 after nisliding
- d) threaded stud pre-turned dim. Ø7,30 -0,06, thread roll tolerance 6e, thread tolerances acc. DIN ISO 965-3
- e) knurl-profile manufactured with knurl roll DIN 82 - RAA 0,5
- f) dims. before grinding for piston rods Ø 8,35 -0,11

Environmental protection acc. to STAB-Spec. 10005649

Ident. Doc.: SN 6742BA

DE: X	EN: X	ES: X	IT:	PR:	FR:	RO: X	CRD created document handwritten changes not permitted
new	Permanent additional inspection 014/01	acc. STAB-Spec. 10258370	100% cleanliness of through hole	Tab. IV			
old	Temporary additional inspection 014/01	RHT 0,4 ... 0,7 mm	Permanent additional inspection 014/01	Tab. VIII			
Field	C-D 5	B 7-8	D/4-5	Pos. 302 + 306			
Date/Name	25.03.2019 Höfer	10.05.2019 Jablonski	09.06.2021 Hein	26.04.2022 Donat			
Chg. No.	671363	678466	677895	710006			
Rev.	32	33	34	35			

Material:	mat.no.: 010146	All dimensions are in mm	Marking of special characteristics according to STAB-Spec. 10270932	Date	26.01.1994	Name	Kornely
Edge tolerances acc. to DIN ISO 13715		Scale: (Original DIN A3) 2:1	Dimensions without tolerances DIN ISO 2768-mK	Checked by	26.04.2022	Milles	
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.:	10004290		
Registries:	SN 6742BA	STABILUS		Material No.:			
		PISTON ROD					