

CONFIDENTIAL!  
Intended for internal use only

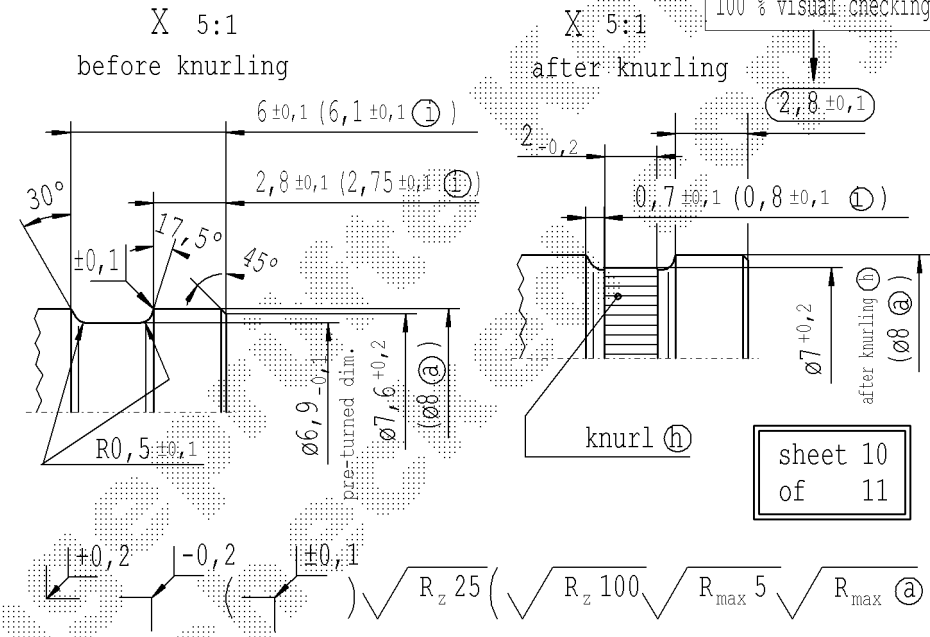
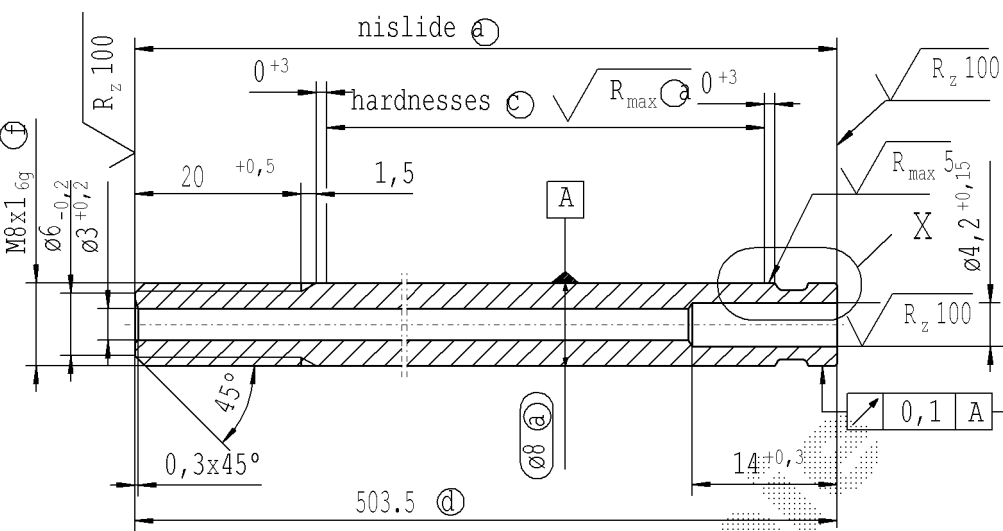
supp. No.	material no.				A	B
	surface treatment processing acc. to STAB-Spec. 10006248					
	table IV Nislide black	table VIII Nislide black	table V Nislide light	table X Nislide "G"		
287				621915	194.5	16
288				631236	293.5	16
289				914690	248.5	16
290				109740	287.5	16
291				323645	503.5	20
292				511260	395.5	16
293				513411	347.5	16
294	520342				446.5	16
295				248602	278.5	16
296			361650		503.5	22
297				805713	83.5	16
298				945767	143.5	22
299	342055				548.5	16
300				295451	155.5	20
301			886498		479.5	16
302	644631				509.5	18
303				524893	296.5	22
304				500995	119.5	16
305	566242				479.5	20
306	839420				473.5	18
307				349472	479.5	20

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

STAB	STES	STGB	STIT	STAU	STUS	STMZ	STNR	STRO
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



- 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.  $\varnothing 7,30_{-0,06}$  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  $\varnothing 8,35_{-0,11}$

sheet 10 of 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	Drawn by	Date	Name
Edge tolerances acc. to DIN ISO 13715		Scale: (Original DIN A3) 2:1	Dimensions without tolerances DIN ISO 2768-mK	Checked by	26.01.1994	Kornely
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	<b>STABILUS</b>		Material No.:	PISTON ROD	