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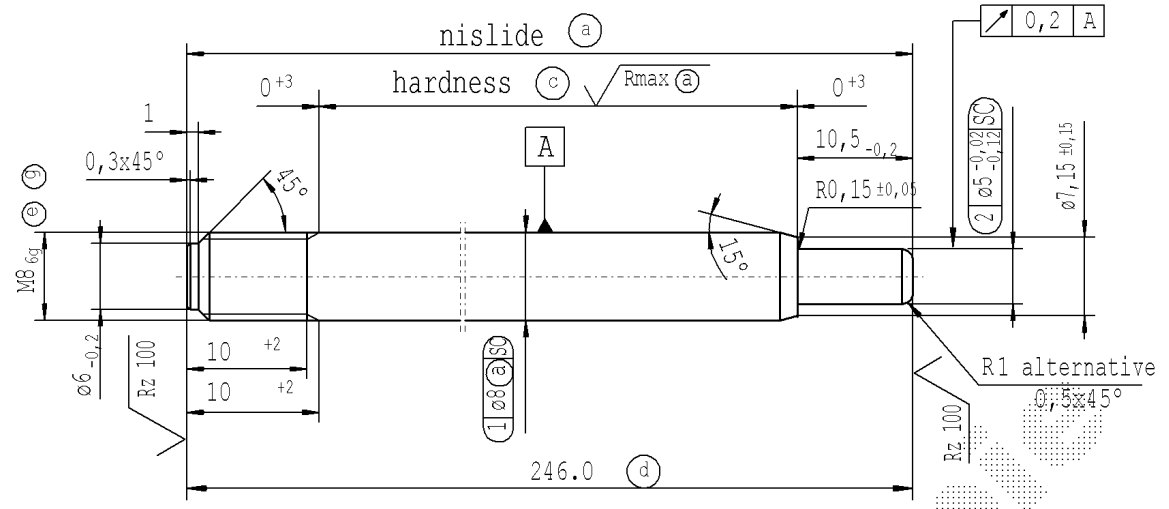
EN

Ident. Doc.:

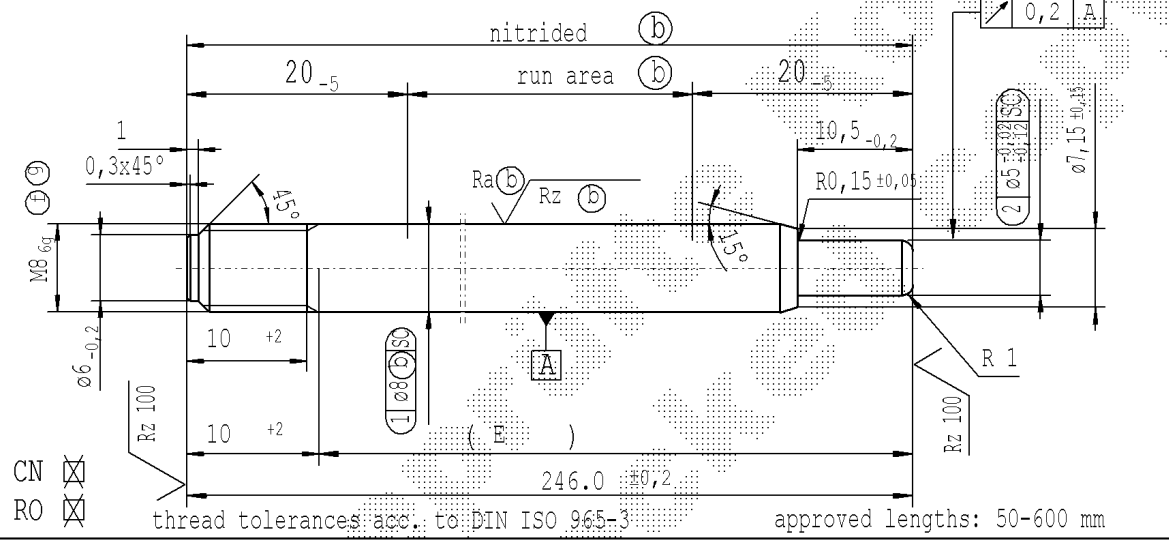
Date/Name: 26.07.2023 Jablonski

supp No.	material no.			A	B
	10006248 Tab. XVI optimized version 1	10006248 Tab. X version 1	10028959 Tab. I version 2	overall length	thread length
3	262925	262925	262925	153.0	10
4	376689	376689	376689	147.0	10
5	192182	192182	192182	204.0	10
7	389835	389835	389835	195.0	12
8	391747	391747	391747	153.0	12
11	941208	941208	941208	108.0	10
12	071966	071966	071966	250.0	10
13	114990	114990	114990	327.0	10
14	782758	782758	782758	321.0	10
15	975631	975631	975631	267.0	10
16	571964	571964	571964	246.0	10
17	426176	426176	426176	162.0	10
18	246210	246210	246210	348.0	10
19	151331	151331	151331	171	6
20	265816	265816	265816	207.0	10
21	569346	569346	569346	276.0	10
22	701035	701035	701035	186.0	10
23	414714	414714	414714	303.0	8
24	322461	322461	322461	300.0	10
25	332499	332499	332499	192.0	10
26	340147	340147	340147	249.0	10

version 1 (only self-manufacturing) * material: 010731



version 2 (only external production) * material: 1.1193 S45C JISG 4051, for ZS-RO alt.: 184083 (C35EC)



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

(d) tolerances: $+0,2$ after turning
 $+0,3$ after straightening
 $+0,3$ after nisliding

(e) threaded stud rough-turned dim. $\phi 7,14_{-0,06}$
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

ZS CN
ZS RO

thread tolerances acc. to DIN ISO 965-3 approved lengths: 50-600 mm

$\sqrt{Rz 25}$ ($\sqrt{Rz 100}$ $\sqrt{Rmax (a)}$ $\sqrt{Ra (b)}$ $\sqrt{Rz (b)}$) $\downarrow +0,2$ $\downarrow -0,2$

sheet 1 of 6

AIAG CQI-standards acc. to STAB-Spec. 10027692						
DE: X	EN: X	ES: X	IT:	PR:	FR:	RO: X
new	version 2 , for ZS-RO alt. 184083 (C35EC)					
old	-					
Field	D/1-5					
Date/Name	26.07.2023 Jablonski					
Chg. No.	724814					
Rev.	9					

Environmental protection acc. to STAB-Spec. 10005649		
Date	Name	
05.03.2014	Höfer	Drawn by
17.01.2024	Klinkner	Checked
Document No.:		10210124
Material No.:		

STABILUS

PISTON ROD